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**THERMALLY DEVELOPABLE IMAGING MATERIALS WITH
REDUCED MOTTLE PROVIDING IMPROVED
IMAGE UNIFORMITY**

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THERMALLY DEVELOPABLE IMAGING MATERIALS WITH REDUCED MOTTLE PROVIDING IMPROVED IMAGE UNIFORMITY

FIELD OF THE INVENTION

5 This invention relates to thermally developable imaging materials
such as photothermographic materials. More particularly, it relates to photo-
thermographic imaging materials that exhibit decreased mottle and improved
image uniformity upon exposure and development. The invention also relates to
methods of preparing these material and methods of imaging using these
10 materials. This invention is directed to the photothermographic imaging industry.

BACKGROUND OF THE INVENTION

 Silver-containing photothermographic imaging materials that are
developed with heat and without liquid development have been known in the art
15 for many years. Such materials are used in a recording process wherein an image
is formed by imagewise exposure of the photothermographic material to specific
electromagnetic radiation (for example, visible, ultraviolet or infrared radiation)
and developed by the use of thermal energy. These materials, also known as "dry
silver" materials, generally comprise a support having coated thereon: (a) a photo-
20 sensitive catalyst (such as silver halide) that upon such exposure provides a latent
image in exposed grains that is capable of acting as a catalyst for the subsequent
formation of a silver image in a development step, (b) a non-photosensitive source
of reducible silver ions, (c) a reducing composition (usually including a developer)
for the reducible silver ions, and (d) a hydrophilic or hydrophobic binder. The
25 latent image is then developed by application of thermal energy.

 In such materials, the photosensitive catalyst is generally a photo-
graphic type photosensitive silver halide that is considered to be in catalytic
proximity to the non-photosensitive source of reducible silver ions. Catalytic
proximity requires intimate physical association of these two components either
30 prior to or during the thermal image development process so that when silver
atoms, $(Ag^0)_n$, also known as silver specks, clusters, nuclei, or latent image, are

generated by irradiation or light exposure of the photosensitive silver halide, those silver atoms are able to catalyze the reduction of the reducible silver ions within a catalytic sphere of influence around the silver atoms [D. H. Klosterboer, in *Imaging Processes and Materials, (Neblette's Eighth Edition)*, J. Sturge, V. Walworth, and A. Shepp, Eds., Van Nostrand-Reinhold, New York, 1989, Chapter 9, pp. 279-291]. It has long been understood that silver atoms act as a catalyst for the reduction of silver ions, and that the photosensitive silver halide can be placed in catalytic proximity with the non-photosensitive source of reducible silver ions in a number of different ways (see, for example, *Research Disclosure*, June 1978, item 17029). Other photosensitive materials, such as titanium dioxide, cadmium sulfide, and zinc oxide, have also been reported to be useful in place of silver halide as the photocatalyst in photothermographic materials [see for example, Shepard, *J. Appl. Photog. Eng.* **1982**, 8(5), 210-212, Shigeo et al., *Nippon Kagaku Kaishi*, **1994**, 11, 992-997, and FR 2,254,047 (Robillard)].

The photosensitive silver halide may be made “*in situ*”, for example, by mixing an organic or inorganic halide-containing source with a source of reducible silver ions to achieve partial metathesis and thus causing the *in situ* formation of silver halide (AgX) grains throughout the silver source [see, for example, U.S. Patent 3,457,075 (Morgan et al.)]. In addition, photosensitive silver halides and sources of reducible silver ions can be coprecipitated [see Usanov et al., *J. Imag. Sci. Tech.* **1996**, 40, 104]. Alternatively, a portion of the reducible silver ions can be completely converted to silver halide, and that portion can be added back to the source of reducible silver ions (see Usanov et al., International Conference on Imaging Science, 7-11 September 1998)

The silver halide may also be “preformed” and prepared by an “*ex situ*” process whereby the silver halide (AgX) grains are prepared and grown separately. With this technique, one has the possibility of controlling the grain size, grain size distribution, dopant levels, and composition much more precisely, so that one can impart more specific properties to both the silver halide grains and the photothermographic material. The preformed silver halide grains may be

introduced prior to, and be present during, the formation of the source of reducible silver ions. Co-precipitation of the silver halide and the source of reducible silver ions provides a more intimate mixture of the two materials [see for example, U.S. Patent 3,839,049 (Simons)]. Alternatively, the preformed silver halide grains may
5 be added to and physically mixed with the source of reducible silver ions.

The non-photosensitive source of reducible silver ions is a material that contains reducible silver ions. Typically, the preferred non-photosensitive source of reducible silver ions is a silver salt of a long chain aliphatic carboxylic acid having from 10 to 30 carbon atoms, or mixtures of such salts. Such acids are
10 also known as "fatty acids" or "fatty carboxylic acids". Silver salts of other organic acids or other organic compounds, such as silver imidazoles, silver tetrazoles, silver benzotriazoles, silver benzotetrazoles, silver benzothiazoles and silver acetylides have also been proposed. U.S. Patent 4,260,677 (Winslow et al.) discloses the use of complexes of various inorganic or organic silver salts.

15 In photothermographic materials, exposure of the photographic silver halide to light produces small clusters containing silver atoms (Ag^0)_n. The imagewise distribution of these clusters, known in the art as a latent image, is generally not visible by ordinary means. Thus, the photosensitive material must be further developed to produce a visible image. This is accomplished by the
20 reduction of silver ions that are in catalytic proximity to silver halide grains bearing the silver-containing clusters of the latent image. This produces a black-and-white image. The non-photosensitive silver source is catalytically reduced to form the visible black-and-white negative image while much of the silver halide, generally, remains as silver halide and is not reduced.

25 In photothermographic materials, the reducing agent for the reducible silver ions, often referred to as a "developer", may be any compound that, in the presence of the latent image, can reduce silver ion to metallic silver and is preferably of relatively low activity until it is heated to a temperature sufficient to cause the reaction. A wide variety of classes of compounds have been disclosed
30 in the literature that function as developers for photothermographic materials. At elevated temperatures, the reducible silver ions are reduced by the reducing agent.

In photothermographic materials, upon heating, this reaction occurs preferentially in the regions surrounding the latent image. This reaction produces a negative image of metallic silver having a color that ranges from yellow to deep black depending upon the presence of toning agents and other components in the
5 imaging layer(s).

Differences Between Photothermography and Photography

The imaging arts have long recognized that the field of photothermography is clearly distinct from that of photography. Photothermographic
10 materials differ significantly from conventional silver halide photographic materials that require processing with aqueous processing solutions.

As noted above, in photothermographic imaging materials, a visible image is created by heat as a result of the reaction of a developer incorporated within the material. Heating at 50°C or more is essential for this dry development.
15 In contrast, conventional photographic imaging materials require processing in aqueous processing baths at more moderate temperatures (from 30°C to 50°C) to provide a visible image.

In photothermographic materials, only a small amount of silver halide is used to capture light and a non-photosensitive source of reducible silver
20 ions (for example, a silver carboxylate) is used to generate the visible image using thermal development. Thus, the imaged photosensitive silver halide serves as a catalyst for the physical development process involving the non-photosensitive source of reducible silver ions and the incorporated reducing agent. In contrast, conventional wet-processed, black-and-white photographic materials use only one
25 form of silver (that is, silver halide) that, upon chemical development, is itself converted into the silver image, or that upon physical development requires addition of an external silver source (or other reducible metal ions that form black images upon reduction to the corresponding metal). Thus, photothermographic materials require an amount of silver halide per unit area that is only a fraction of
30 that used in conventional wet-processed photographic materials.

In photothermographic materials, all of the “chemistry” for imaging is incorporated within the material itself. For example, such materials include a developer (that is, a reducing agent for the reducible silver ions) while conventional photographic materials usually do not. Even in so-called “instant photography”, the developer chemistry is physically separated from the photo-sensitive silver halide until development is desired. The incorporation of the developer into photothermographic materials can lead to increased formation of various types of “fog” or other undesirable sensitometric side effects. Therefore, much effort has gone into the preparation and manufacture of photothermographic materials to minimize these problems during the preparation of the photothermographic emulsion as well as during coating, use, storage, and post-processing handling.

Moreover, in photothermographic materials, the unexposed silver halide generally remains intact after development and the material must be stabilized against further imaging and development. In contrast, silver halide is removed from conventional photographic materials after solution development to prevent further imaging (that is, in the aqueous fixing step).

In photothermographic materials, the binder is capable of wide variation and a number of binders (both hydrophilic and hydrophobic) are useful. In contrast, conventional photographic materials are limited almost exclusively to hydrophilic colloidal binders such as gelatin.

Because photothermographic materials require dry thermal processing, they present distinctly different problems and require different materials in manufacture and use, compared to conventional, wet-processed silver halide photographic materials. Additives that have one effect in conventional silver halide photographic materials may behave quite differently when incorporated in photothermographic materials where the underlying chemistry is significantly more complex. The incorporation of such additives as, for example, stabilizers, antifoggants, speed enhancers, supersensitizers, and spectral and chemical sensitizers in conventional photographic materials is not predictive of whether such additives will prove beneficial or detrimental in photothermographic

materials. For example, it is not uncommon for a photographic antifoggant useful in conventional photographic materials to cause various types of fog when incorporated into photothermographic materials, or for supersensitizers that are effective in photographic materials to be inactive in photothermographic materials.

5 These and other distinctions between photothermographic and photographic materials are described in *Imaging Processes and Materials* (Neblette's Eighth Edition), noted above, *Unconventional Imaging Processes*, E. Brinckman et al., Eds., The Focal Press, London and New York, 1978, pp. 74-75, in Zou et al., *J. Imaging Sci. Technol.* **1996**, *40*, pp. 94-103, and in
10 M. R. V Sahyun, *J. Imaging Sci. Technol.*, **1998**, *42*, 23.

Problem to be Solved

 Thermally developable materials have gained widespread use in several industries, particularly in radiography. Such materials are usually
15 constructed by coating layer formulations from solution and removing as much of the solvent as possible by drying. Problems that arise with this manufacturing process include the formation of coating defects that can be attributed to the various coating and drying conditions and procedures.

 One such coating defect, referred to as "mottle", arises from an
20 unevenness in the distribution of solid materials formed within a coating as solvent is removed during drying [see, for example, *Modern Coating and Drying Technology*, Eds. E. D. Cohen and E. B. Gutoff, Eds., VCH Publishers, New York, 1992, p. 288]. It is believed to be caused by a non-uniform airflow blowing the coating around in the early stages of the drying process when the coating is
25 still quite fluid. This can occur in the coating before it enters the dryer, as it enters the dryer, or in the dryer and can be more severe with coating solvents of increased volatility [see, for example, *Coating and Drying Defects: Troubleshooting Operating Problems*, E. B. Gutoff and E. D. Cohen, John Wiley and Sons, New
York, 1995, p. 203].

30 In a coated material, mottle appears as an irregular pattern of non-uniform density that appears blotchy when viewed. The pattern may take on

an orientation or direction. The scale can be quite small or quite large and may be on the order of centimeters. The blotches may appear to have different colors or shades of colors and can be gross or subtle.

5 Mottle may not be readily apparent in undeveloped photothermo-
graphic materials but upon thermal development it becomes more evident. For
example, in black-and-white photothermographic materials upon development the
resulting non-uniform image density may appear as shades of gray.

10 Various techniques have been used for reducing mottle in coated
materials. For example, to reduce the severity of non-uniform airflow on the
undried coating, dryer airflow and web speed can be reduced. However, this can
lower the coating line speed, reduce manufacturing efficiency, and increase
manufacturing costs.

Careful control of oven design, as well as coating and/or drying
conditions, have also been used to control mottle. Some of these techniques are
15 described in U.S. Patent 4,051,278 (Democh), U.S. Patent 5,881,476 (Strobush et
al.), and U.S. Patent 5,621,983 (Ludemann et al.).

Surfactants have also been incorporated into coating formulations
used to reduce mottle, including for example fluorinated surfactants as described
for example in U.S. Patent 5,380,644 (Yonkoski et al.) and U.S. Patent 5,532,121
20 (Yonkoski et al.). However, the use of surfactants may lead to other problems as
they may adversely affect the sensitometric properties of the imaging materials as
well as their ability to be fed and transported within the imaging apparatus.

The techniques described above may limit the manufacturability of
the materials, produce other undesirable properties in the materials, or may not
25 sufficiently reduce mottle for all imaging material requirements.

Furthermore, it is known in the imaging arts, including photo-
thermographic art, to incorporate acutance dyes into imaging layers to improve
sharpness [see for example, U.S. Patent 5,380,635 (Gomez et al.) and U.S. Patent
5,922,529 (Tsuzuki et al.)]. It is also known to add such materials to reduce
30 interference fringes during laser exposure [see for example, U.S. Patent 5,998,126
(Toya et al.)], and to reduce "woodgrain"[see for example, EP 0 792 476 B1

(Geisler et al.)). The acutance dyes are incorporated into the photothermographic materials in an amount necessary to provide an absorbance in the range of 0.05 to 0.6. Higher absorbance is not believed to provide additional benefits in image sharpness or reduction of interference fringes.

5 Also, the quality of the sharpness or the interference fringes in a photothermographic material is not affected by non-uniform airflow blowing the fluid coating around in the early stages of drying. Therefore, improvements in these characteristics have not been directly related to coating and drying processes, particularly web speed during drying.

10 It is desirable to reduce the formation of mottle during manufacture of photothermographic materials without the use of surfactants or modification of coating and drying procedures. In particular, it is desirable to reduce mottle without reducing web speed during drying.

15 SUMMARY OF THE INVENTION

 This invention provides a photothermographic material that comprises a support having thereon one or more thermally-developable imaging layers comprising a binder and in reactive association, a photosensitive silver halide, a non-photosensitive source of reducible silver ions, and a reducing
20 composition for the non-photosensitive source of reducible silver ions,

 wherein the one or more thermally-developable imaging layers further comprise one or more radiation absorbing substances that provide a total absorbance in the one or more thermally-developable imaging layers of greater than 0.6 and up to and including 3 at an exposure wavelength,
25 the one or more thermally-developable imaging layers having been independently coated and dried while the material is conveyed at a rate of at least 5 meters per minute.

 The photothermographic materials of this invention exhibit reduced mottle after imaging and thermal development. The appearance of mottle is
30 reduced without having to use surfactants in the coated layers and without

adjusting coating and drying conditions in manufacturing operations, thereby providing an improved imaging material with good manufacturability.

These advantages have been achieved by incorporating certain radiation absorbing compounds (generally dyes) in the one or more thermally developable imaging layers of the photothermographic materials in a quantity sufficient to provide a total optical density (or absorbance) in those layers of greater than 0.6 and up to and including 3. These absorbing compounds may not reduce the susceptibility of the wet coatings to being blown about by non-uniform airflow, but they reduce the appearance of mottle in the imaged and developed photothermographic material.

In addition, the dyes must not interfere with the manufacturing process and permit high speed coating and drying (at least 5 m/min. for each of these manufacturing steps) of the photothermographic material.

In another embodiment, this invention provides a photothermographic material having one or more thermally developable imaging layers on both sides of the support.

Further, a method of this invention for forming a visible image comprises:

- A) imagewise exposing the black and white photothermographic material described above to electromagnetic radiation at a wavelength greater than 700 nm to form a latent image, and
- B) simultaneously or sequentially, heating the exposed photothermographic material to develop the latent image into a visible image.

When the photothermographic materials of this invention are heat-developed, as described below, in a substantially water-free condition after, or simultaneously with, imagewise exposure, a silver image (preferably a black-and-white silver image) is obtained. The photothermographic material may be exposed in step A using an laser, a laser diode, a light-emitting screen, CRT tube, a light-emitting diode, a light bar, or other radiation source readily apparent to one skilled in the art.

In some embodiments of the imaging method of this invention, the photothermographic material has a transparent support and the imaging method further includes:

5 C) positioning the exposed and heat-developed photothermographic material between a source of imaging radiation and an imageable material that is sensitive to the imaging radiation, and

D) thereafter exposing the imageable material to the imaging radiation through the visible image in the exposed and heat-developed photothermographic material to provide an image in the imageable material.

10 Preferred embodiments of this invention include black-and-white photothermographic materials each comprising a support having on one side thereof:

a) a thermally-developable imaging layer comprising a hydrophobic binder and in reactive association, a photosensitive silver bromide or
15 silver bromoiodide, or mixtures thereof, one or more non-photosensitive silver carboxylates, at least one of which is silver behenate, and a merocyanine or cyanine spectral sensitizing dye,

b) a protective layer that is farther from the support than the imaging layer,

20 the photothermographic material also comprising an antihalation layer on the backside of the support, the antihalation layer comprising a binder and at least one antihalation dye,

wherein the thermally-developable imaging layer further comprises one or more radiation absorbing substances that provide a total absorbance in the
25 one or more thermally-developable imaging layers of greater than 0.6 and up to and including 3 at an exposure wavelength,

the one or more radiation absorbing substances being cyanine, hemicyanine, merocyanine, squaraine, or oxanol dyes, or mixtures thereof, and

30 the one or more thermally-developable imaging layers having been coated and dried while the material is conveyed at a rate of at least 5 meters per minute.

This invention further provides a method of preparing the above photothermographic element, comprising the steps of:

5 A) preparing a formulation or formulations comprising a binder and in reactive association, a photosensitive silver halide, a non-photosensitive source of reducible silver ions, a reducing composition for the non-photosensitive source reducible silver ions, and a radiation absorbing compound or compounds that absorb at an exposure wavelength,

10 B) independently coating these formulations on a support in a manner such that, at the exposure wavelength, the total absorbance of all thermally-developable imaging layers is greater than 0.6, and drying them while the material is conveyed at a rate of at least 5 meters per minute.

This invention further provides a method of reducing mottle in a photothermographic material, comprising the steps of:

15 A) preparing a formulation or formulations comprising a binder and in reactive association, a photosensitive silver halide, a non-photosensitive source of reducible silver ions, a reducing composition for the non-photosensitive source reducible silver ions, and a radiation absorbing compound or compounds that absorb at an exposure wavelength,

20 B) coating these formulations on a support in a manner such that, at the exposure wavelength, the total absorbance of all thermally-developable imaging layers is greater than 0.6.

25 The photothermographic materials of this invention exhibit reduced mottle after imaging and thermal development. The appearance of mottle is reduced without having to use surfactants in the coated layers and without adjusting coating and drying conditions in manufacturing operations, thereby providing an improved imaging material with good manufacturability.

BRIEF DESCRIPTION OF THE DRAWING

30 Figure 1 is a graphical representation of “mottle rating” vs. spectral absorbance for the photothermographic materials that were prepared and evaluated in Example 1 below.

DETAILED DESCRIPTION OF THE INVENTION

The photothermographic materials of this invention can be used, for example, in conventional black-and-white or color photothermography, and in
5 electronically generated black-and-white or color hardcopy recording. They can be used in microfilm applications, in radiographic imaging (for example, digital medical imaging), and industrial radiography. Furthermore, the absorbance of these photothermographic materials between 350 and 450 nm is desirably low (less than 0.5), to permit their use in the graphic arts area (for example, image-
10 setting and phototypesetting), in the manufacture of printing plates, in contact printing, in duplicating (“duping”), and in proofing. The photothermographic materials of this invention are particularly useful for medical radiography to provide black-and-white images.

In one embodiment, the photothermographic materials of this
15 invention are sensitive to radiation at a wavelength of at least 700 nm, and preferably at a wavelength of from about 750 to about 1400 nm.

In the photothermographic materials of this invention, the components needed for imaging can be in one or more layers. The layer(s) that contain the photosensitive photocatalyst (such as a photosensitive silver halide) or
20 non-photosensitive source of reducible silver ions, or both, are referred to herein as photothermographic emulsion layer(s). The photocatalyst and the non-photosensitive source of reducible silver ions are in catalytic proximity (or reactive association) and preferably are in the same emulsion layer.

Various layers are usually disposed on the “backside”
25 (non-emulsion side) of the materials, including additional photothermographic layers, antihalation layer(s), protective layers, antistatic layers, conducting layers, and transport enabling layers.

Various layers are also usually disposed on the “frontside” or emulsion side of the support, including protective topcoat layers, barrier layers,
30 primer layers, interlayers, opacifying layers, antistatic layers, antihalation layers,

acutance layers, auxiliary layers, and others readily apparent to one skilled in the art.

In preferred embodiments of the present invention the photo-thermographic materials further comprise a surface protective layer on the same
5 side of the support as the one or more thermally-developable layers, an antihalation layer on the opposite side of the support, or both a surface protective layer and an antihalation layer on their respective sides of the support.

Definitions

10 As used herein:

In the descriptions of the photothermographic materials of the present invention, “a” or “an” component refers to “at least one” of that component. For example, the radiation absorbing substances described herein can be used individually or in mixtures.

15 Heating in a substantially water-free condition as used herein, means heating at a temperature of from about 50°C to about 250°C with little more than ambient water vapor present. The term “substantially water-free condition” means that the reaction system is approximately in equilibrium with water in the air and water for inducing or promoting the reaction is not particularly
20 or positively supplied from the exterior to the material. Such a condition is described in T. H. James, *The Theory of the Photographic Process*, Fourth Edition, 1977, p. 374.

“Photothermographic material(s)” means a construction comprising at least one photothermographic emulsion layer or a photothermographic set of
25 layers (wherein the silver halide and the source of reducible silver ions are in one layer and the other essential components or desirable additives are distributed, as desired, in an adjacent coating layer) and any supports, topcoat layers, image-receiving layers, blocking layers, antihalation layers, subbing or priming layers. These materials also include multilayer constructions in which one or more
30 imaging components are in different layers, but are in “reactive association” so that they readily come into contact with each other during imaging and/or

development. For example, one layer can include the non-photosensitive source of reducible silver ions and another layer can include the reducing composition, but the two reactive components are in reactive association with each other.

“Emulsion layer”, “imaging layer”, or “photothermographic emulsion layer”, means a layer of a photothermographic material that contains the photosensitive silver halide and/or non-photosensitive source of reducible silver ions. It can also mean a layer of the photothermographic material that contains, in addition to the photosensitive silver halide and/or non-photosensitive source of reducible ions, additional essential components and/or desirable additives. These layers are usually on what is known as the “frontside” of the support.

“Ultraviolet region of the spectrum” refers to that region of the spectrum less than or equal to 410 nm, and preferably from about 100 nm to about 410 nm, although parts of these ranges may be visible to the naked human eye. More preferably, the ultraviolet region of the spectrum is the region of from about 190 to about 405 nm.

“Visible region of the spectrum” refers to that region of the spectrum of from about 400 nm to about 700 nm.

“Short wavelength visible region of the spectrum” refers to that region of the spectrum from about 400 nm to about 450 nm.

“Red region of the spectrum” refers to that region of the spectrum of from about 600 nm to about 700 nm.

“Infrared region of the spectrum” refers to that region of the spectrum of from about 700 nm to about 1400 nm.

An auxochrome is a group of atoms that when conjugated to a chromophore intensifies and/or shifts the color of that chromophore.

“Non-photosensitive” means not intentionally light sensitive.

“Transparent” means capable of transmitting visible light or imaging radiation without appreciable scattering or absorption.

“Dye base” means a compound derived from a quaternized heterocyclic ammonium salt and containing an electrophilically-reactive olefinic methylene or methine group conjugatively located to the nitrogen atom of the

ammonium salt. Basic nuclei are discussed in C. E. K. Mees and T. H. James, *The Theory of the Photographic Process*, Fourth Edition, 1977, pp. 198-200.

"Electron-donating" means a group that contributes to the electron density of a π -electron system.

5 "Electron-withdrawing" means a group that attracts electron density from a π -electron system.

The electron-donating and electron withdrawing nature of a chemical group may be determined by a variety of methods. The Hammett sigma value (σ) is an accepted measure of a group's electron-donating and withdrawing
10 ability, especially the sigma *para* value (σ_p). See, for example, O. Exner in *Advances in Linear-Free-Energy Relationships*, Chapman, N. B. and Shorter, J., Eds., Plenum, New York, 1972, pp. 28-30, 41-45, and 50-52.

The sensitometric terms "photospeed" or "photographic speed" (also known as "sensitivity"), "contrast", D_{min} , and D_{max} have conventional
15 definitions known in the imaging arts.

The sensitometric term optical density is another term for "absorbance."

In the compounds described herein, no particular double bond geometry (for example, *cis* or *trans*) is intended by the structures drawn.
20 Similarly, the alternating single and double bonds and localized charges are drawn as a formalism. In reality, both electron and charge delocalization exists throughout the conjugated chain.

As is well understood in this art, for the compounds described herein, substitution is not only tolerated, but is often advisable and various
25 substituents are anticipated on the compounds used in the present invention. Thus, when a compound is referred to as "having the structure" of a given formula, any substitution that does not alter the bond structure of the formula or the shown atoms within that structure is included within the formula, unless such substitution is specifically excluded by language (such as "free of carboxy-substituted alkyl").
30 For example, where a benzene ring structure is shown (including fused ring

structures), substituent groups may be placed on the benzene ring structure, but the atoms making up the benzene ring structure may not be replaced.

As a means of simplifying the discussion and recitation of certain substituent groups, the term "group" refers to chemical species that may be substituted as well as those that are not so substituted. Thus, the term "group", such as "alkyl group" is intended to include not only pure hydrocarbon alkyl chains, such as methyl, ethyl, *n*-propyl, *t*-butyl, cyclohexyl, *iso*-octyl, and octadecyl, but also alkyl chains bearing substituents known in the art, such as hydroxyl, alkoxy, phenyl, halogen atoms (F, Cl, Br, and I), cyano, nitro, amino, and carboxy. For example, alkyl group includes ether and thioether groups (for example, CH₃-CH₂-CH₂-O-CH₂- and CH₃-CH₂-CH₂-S-CH₂-), haloalkyl, nitroalkyl, alkylcarboxy, carboxyalkyl, carboxamido, hydroxyalkyl, sulfoalkyl, and other groups readily apparent to one skilled in the art. Substituents that adversely react with other active ingredients, such as very strongly electrophilic or oxidizing substituents, would, of course, be excluded by the ordinarily skilled artisan as not being inert or harmless.

Research Disclosure is a publication of Kenneth Mason Publications Ltd., Dudley House, 12 North Street, Emsworth, Hampshire PO10 7DQ England (also available from Emsworth Design Inc., 147 West 24th Street, New York, N.Y. 10011).

Other aspects, advantages, and benefits of the present invention are apparent from the detailed description, examples, and claims provided in this application.

25 The Photocatalyst

As noted above, the photothermographic materials of the present invention include one or more photocatalysts in the photothermographic emulsion layer(s). Useful photocatalysts are typically silver halides such as silver bromide, silver iodide, silver chloride, silver bromiodide, silver chlorobromiodide, silver chlorobromide and others readily apparent to one skilled in the art. Mixtures of silver halides can also be used in any suitable proportion. Silver bromide and

silver bromoiodide are more preferred, with the latter silver halide having up to 10 mol % silver iodide. Typical techniques for preparing and precipitating silver halide grains are described in *Research Disclosure*, 1978, Item 17643.

5 The shape of the photosensitive silver halide grains used in the present invention is in no way limited. The silver halide grains may have any crystalline habit including, but not limited to, cubic, octahedral, tetrahedral, orthorhombic, rhombic, dodecahedral, other polyhedral, tabular, laminar, twinned, or platelet morphologies, and may have epitaxial growth of crystals thereon. If desired, a mixture of these crystals may be employed. Silver halide grains having
10 cubic and tabular morphology are preferred.

The silver halide grains may have a uniform ratio of halide throughout. They may have a graded halide content, with a continuously varying ratio of, for example, silver bromide and silver iodide or they may be of the core-shell type, having a discrete core of one halide ratio, and a discrete shell of
15 another halide ratio. Core-shell silver halide grains useful in photothermographic materials and methods of preparing these materials are described for example, in U.S. Patent 5,382,504 (Shor et al.), incorporated herein by reference. Iridium and/or copper doped core-shell and non-core-shell grains are described in U.S. Patent 5,434,043 (Zou et al.) and U.S. Patent 5,939,249 (Zou), both incorporated
20 herein by reference.

The photosensitive silver halide can be added to (or formed within) the emulsion layer(s) in any fashion as long as it is placed in catalytic proximity to the non-photosensitive source of reducible silver ions.

It is preferred that the silver halides be preformed and prepared by
25 an *ex-situ* process. The silver halide grains prepared *ex-situ* may then be added to and physically mixed with the non-photosensitive source of reducible silver ions. It is more preferable to form the source of reducible silver ions in the presence of *ex-situ*-prepared silver halide. In this process, the source of reducible silver ions, such as a long chain fatty acid silver carboxylate (commonly referred to as a silver
30 "soap"), is formed in the presence of the preformed silver halide grains. Co-precipitation of the reducible source of silver ions in the presence of silver

halide provides a more intimate mixture of the two materials [see, for example, U.S. Patent 3,839,049 (Simons)]. Materials of this type are often referred to as “preformed soaps”.

5 The silver halide grains used in the imaging formulations can vary in average diameter of up to several micrometers (μm) depending on their desired use. Preferred silver halide grains are those having an average particle size of from about 0.01 to about 1.5 μm , more preferred are those having an average particle size of from about 0.03 to about 1.0 μm , and most preferred are those having an average particle size of from about 0.05 to about 0.8 μm . Those of
10 ordinary skill in the art understand that there is a finite lower practical limit for silver halide grains that is partially dependent upon the wavelengths to which the grains are spectrally sensitized. Such a lower limit, for example, is typically from about 0.01 to about 0.005 μm .

15 The average size of the photosensitive doped silver halide grains is expressed by the average diameter if the grains are spherical, and by the average of the diameters of equivalent circles for the projected images if the grains are cubic or in other non-spherical shapes.

Grain size may be determined by any of the methods commonly employed in the art for particle size measurement. Representative methods are
20 described by in “Particle Size Analysis”, ASTM Symposium on Light Microscopy, R. P. Loveland, 1955, pp. 94-122, and in C. E. K. Mees and T. H. James, *The Theory of the Photographic Process*, Third Edition, Macmillan, New York, 1966, Chapter 2. Particle size measurements may be expressed in terms of the projected areas of grains or approximations of their diameters. These will provide
25 reasonably accurate results if the grains of interest are substantially uniform in shape.

Preformed silver halide emulsions used in the material of this invention can be prepared by aqueous or organic processes and can be unwashed or washed to remove soluble salts. In the latter case, the soluble salts can be
30 removed by ultrafiltration, by chill setting and leaching, or by washing the coagulum [for example, by the procedures described in U.S. Patent 2,618,556

(Hewitson et al.), U.S. Patent 2,614,928 (Yutzy et al.), U.S. Patent 2,565,418 (Yackel), U.S. Patent 3,241,969 (Hart et al.) and U.S. Patent 2,489,341 (Waller et al.)].

5 It is also effective to use an *in situ* process in which a halide-containing compound is added to an organic silver salt to partially convert the silver of the organic silver salt to silver halide. The halogen-containing compound can be inorganic (such as zinc bromide or lithium bromide) or organic (such as N-bromosuccinimide).

10 Additional methods of preparing these silver halide and organic silver salts and manners of blending them are described in *Research Disclosure*, June 1978, item 17029, U.S. Patent 3,700,458 (Lindholm) and U.S. Patent 4,076,539 (Ikenoue et al.), and JP Applications 13224/74, 42529/76, and 17216/75.

15 In some instances, it may be helpful to prepare the photosensitive silver halide grains in the presence of a hydroxytetrazaindene (such as 4-hydroxy-6-methyl-1,3,3,3a,7-tetrazaindene) or an N-heterocyclic compound comprising at least one mercapto group (such as 1-phenyl-5-mercaptotetrazole) to provide increased photospeed. Details of this procedure are provided in copending and commonly assigned U.S. Serial No. 09/833,533 (filed April 12, 2001 by Shor,
20 Zou, Ulrich, and Simpson), incorporated herein by reference.

The one or more light-sensitive silver halides used in the photo-thermographic materials of the present invention are preferably present in an amount of from about 0.005 to about 0.5 mole, more preferably from about 0.01 to about 0.25 mole, and most preferably from about 0.03 to about 0.15 mole, per
25 mole of non-photosensitive source of reducible silver ions.

Chemical and Spectral Sensitizers

30 The photosensitive silver halides used in the invention may be employed without modification. However, one or more conventional chemical sensitizers may be used in the preparation of the photosensitive silver halides to increase photospeed. Such compounds may contain sulfur, tellurium, or selenium,

or may comprise a compound containing gold, platinum, palladium, ruthenium, rhodium, iridium, or combinations thereof, a reducing agent such as a tin halide or a combination of any of these. The details of these materials are provided for example, in T. H. James, *The Theory of the Photographic Process*, Fourth Edition, 1977, Chapter 5, pp. 149-169. Suitable conventional chemical sensitization procedures are also described in U.S. Patent 1,623,499 (Sheppard et al.), U.S. Patent 2,399,083 (Waller et al.), U.S. Patent 3,297,447 (McVeigh), U.S. Patent 3,297,446 (Dunn), U.S. Patent 5,049,485 (Deaton), U.S. Patent 5,252,455 (Deaton), U.S. Patent 5,391,727 (Deaton), U.S. Patent 5,912,111 (Lok et al.), U.S. Patent 5,759,761 (Lushington et al.), and EP-A-0 915,371 (Lok et al.).

In one embodiment, chemical sensitization is achieved by oxidative decomposition of a spectral sensitizing dye in the presence of a photothermographic emulsion. Such sensitization is described in U.S. Patent 5,891,615 (Winslow et al.), incorporated herein by reference.

In another embodiment, certain substituted and unsubstituted thiourea compounds can be used as chemical sensitizers. Particularly useful tetra-substituted thioureas are described in copending and commonly assigned U.S. Serial No. 09/667,748 (filed September 21, 2000 by Lynch, Simpson, Shor, Willett, and Zou), that is incorporated herein by reference.

Still other useful chemical sensitizers include certain tellurium-containing compounds that are described in copending and commonly assigned U.S. Serial No. 09/975,909 (filed October 11, 2001 by Lynch, Opatz, Shor, Simpson, Willett, and Gysling), that is incorporated herein by reference.

Combinations of gold(III)-containing compounds and either sulfur- or tellurium-containing compounds are useful as chemical sensitizers as described in copending and commonly assigned U.S. Serial No. 09/768,094 (filed January 23, 2001 by Simpson, Shor, and Whitcomb), that is also incorporated herein by reference.

The chemical sensitizers can be used in making the silver halide emulsions in conventional amounts that generally depend upon the average size of the silver halide grains. Generally, the total amount is at least 10^{-10} mole per mole

of total silver, and preferably from about 10^{-8} to about 10^{-2} mole per mole of total silver for silver halide grains having an average size of from about 0.01 to about 2 μm . The upper limit can vary depending upon the compound(s) used, the level of silver halide and the average grain size, and would be readily determinable by one of ordinary skill in the art.

In general, it may also be desirable to add spectral sensitizing dyes to enhance silver halide sensitivity to ultraviolet, visible, and infrared light. Thus, the photosensitive silver halides may be spectrally sensitized with various dyes that are known to spectrally sensitize silver halide. Non-limiting examples of sensitizing dyes that can be employed include cyanine dyes, merocyanine dyes, complex cyanine dyes, complex merocyanine dyes, holopolar cyanine dyes, hemicyanine dyes, styryl dyes, and hemioxanol dyes. The cyanine dyes, merocyanine dyes and complex merocyanine dyes are particularly useful. The cyanine dyes preferably include benzothiazole, benzoxazole, and benzoselenazole dyes that include one or more alkylthio, arylthio, or thioether groups. Suitable sensitizing dyes such as those described in U.S. Patent 3,719,495 (Lea), U.S. Patent 5,393,654 (Burrows et al.), U.S. Patent 5,441,866 (Miller et al.) and U.S. Patent 5,541,054 (Miller et al.), U.S. Patent 5,281,515 (Delprato et al.), and U.S. Patent 5,314,795 (Helland et al.) can be used in the practice of the invention. All of the patents above are incorporated herein by reference.

An appropriate amount of spectral sensitizing dye added is generally about 10^{-10} to 10^{-1} mole, and preferably, about 10^{-7} to 10^{-2} mole per mole of silver halide.

Non-Photosensitive Source of Reducible Silver Ions

The non-photosensitive source of reducible silver ions used in photothermographic materials of this invention can be any compound that contains reducible silver (1+) ions. Preferably, it is a silver salt that is comparatively stable to light and forms a silver image when heated to 50°C or higher in the presence of an exposed photocatalyst (such as silver halide) and a reducing composition.

Silver salts of organic acids, particularly silver salts of long-chain carboxylic acids are preferred. The chains typically contain 10 to 30, and preferably 15 to 28, carbon atoms. Suitable organic silver salts include silver salts of organic compounds having a carboxylic acid group. Examples thereof include a silver salt of an aliphatic carboxylic acid or a silver salt of an aromatic carboxylic acid. Preferred examples of the silver salts of aliphatic carboxylic acids include silver behenate, silver arachidate, silver stearate, silver oleate, silver laurate, silver caprate, silver myristate, silver palmitate, silver maleate, silver fumarate, silver tartarate, silver furoate, silver linoleate, silver butyrate, silver camphorate, and mixtures thereof. Preferably, at least silver behenate is used alone or in mixtures with other silver salts.

Preferred examples of the silver salts of aromatic carboxylic acid and other carboxylic acid group-containing compounds include, but are not limited to, silver benzoate, and silver substituted-benzoates, (such as silver 3,5-dihydroxybenzoate, silver *o*-methylbenzoate, silver *m*-methylbenzoate, silver *p*-methylbenzoate, silver 2,4-dichlorobenzoate, silver acetamidobenzoate, silver *p*-phenylbenzoate, silver tannate, silver phthalate, silver terephthalate, silver salicylate, silver phenylacetate, and silver pyromellitate).

Silver salts of aliphatic carboxylic acids containing a thioether group as described in U.S. Patent 3,330,663 (Weyde et al.) are also useful. Soluble silver carboxylates comprising hydrocarbon chains incorporating ether or thioether linkages, or sterically hindered substitution in the α - (on a hydrocarbon group) or *ortho*- (on an aromatic group) position, and displaying increased solubility in coating solvents and affording coatings with less light scattering can also be used. Such silver carboxylates are described in U.S. Patent 5,491,059 (Whitcomb). Mixtures of any of the silver salts described herein can also be used if desired.

Silver salts of sulfonates are also useful in the practice of this invention. Such materials are described, for example, in U.S. Patent 4,504,575 (Lee). Silver salts of sulfosuccinates are also useful as described for example, in EP-A-0 227 141 (Leenders et al.).

Silver salts of compounds containing mercapto or thione groups and derivatives thereof can also be used. Preferred examples of these compounds include, but are not limited to, a silver salt of 3-mercapto-4-phenyl-1,2,4-triazole, a silver salt of 2-mercaptobenzimidazole, a silver salt of 2-mercapto-5-amino-
5 thiadiazole, a silver salt of 2-(2-ethylglycolamido)benzothiazole, silver salts of thioglycolic acids (such as a silver salt of a S-alkylthioglycolic acid, wherein the alkyl group has from 12 to 22 carbon atoms), silver salts of dithiocarboxylic acids (such as a silver salt of dithioacetic acid), a silver salt of thioamide, a silver salt of 5-carboxylic-1-methyl-2-phenyl-4-thiopyridine, a silver salt of mercaptotriazine, a
10 silver salt of 2-mercaptobenzoxazole, silver salts as described in U.S. Patent 4,123,274 (Knight et al.) (for example, a silver salt of a 1,2,4-mercaptotriazole derivative, such as a silver salt of 3-amino-5-benzylthio-1,2,4-triazole), and a silver salt of thione compounds [such as a silver salt of 3-(2-carboxyethyl)-4-methyl-4-thiazoline-2-thione as described in U.S. Patent 3,785,830 (Sullivan et
15 al.)].

Furthermore, a silver salt of a compound containing an imino group can be used. Preferred examples of these compounds include, but are not limited to, silver salts of benzotriazole and substituted derivatives thereof (for example, silver methylbenzotriazole and silver 5-chlorobenzotriazole), silver salts of
20 1,2,4-triazoles or 1-*H*-tetrazoles such as phenylmercaptotetrazole as described in U.S. Patent 4,220,709 (deMauriac), and silver salts of imidazoles and imidazole derivatives as described in U.S. Patent 4,260,677 (Winslow et al.). Moreover, silver salts of acetylenes can also be used as described, for example, in U.S. Patent 4,761,361 (Ozaki et al.) and U.S. Patent 4,775,613 (Hirai et al.).

25 It is also convenient to use silver half soaps. A preferred example of a silver half soap is an equimolar blend of silver carboxylate and carboxylic acid, which analyzes for about 14.5% by weight solids of silver in the blend and which is prepared by precipitation from an aqueous solution of an ammonium or an alkali metal salt of a commercial fatty carboxylic acid, or by addition of the free
30 fatty acid to the silver soap. For transparent films a silver carboxylate full soap, containing not more than about 15% of free fatty carboxylic acid and analyzing for

about 22% silver, can be used. For opaque photothermographic materials, different amounts can be used.

The methods used for making silver soap emulsions are well known in the art and are disclosed in *Research Disclosure*, April 1983, item 22812, *Research Disclosure*, October 1983, item 23419, U.S. Patent 3,985,565 (Gabrielsen et al.) and the references cited above.

Non-photosensitive sources of reducible silver ions can also be provided as core-shell silver salts such as those described in commonly assigned and copending U.S. Serial No. 09/761,954 (filed January 17, 2001 by Whitcomb and Pham), that is incorporated herein by reference. These silver salts include a core comprised of one or more silver salts and a shell having one or more different silver salts.

Still another useful source of non-photosensitive reducible silver ions in the practice of this invention are the silver dimer compounds that comprise two different silver salts as described in copending U.S. Serial No. 09/812,597 (filed March 20, 2001 by Whitcomb), that is incorporated herein by reference. Such non-photosensitive silver dimer compounds comprise two different silver salts, provided that when the two different silver salts comprise straight-chain, saturated hydrocarbon groups as the silver coordinating ligands, those ligands differ by at least 6 carbon atoms.

As one skilled in the art would understand, the non-photosensitive source of reducible silver ions can include various mixtures of the various silver salt compounds described herein, in any desirable proportions.

The photocatalyst and the non-photosensitive source of reducible silver ions must be in catalytic proximity (that is, reactive association). "Catalytic proximity" or "reactive association" means that they should be in the same layer, or in adjacent layers. It is preferred that these reactive components be present in the same emulsion layer.

The one or more non-photosensitive sources of reducible silver ions are preferably present in an amount of about 5% by weight to about 70% by weight, and more preferably, about 10% to about 50% by weight, based on the

total dry weight of the emulsion layers. Stated another way, the amount of the sources of reducible silver ions is generally present in an amount of from about 0.001 to about 0.2 mol/m² of dried photothermographic material, and preferably from about 0.01 to about 0.05 mol/m² of that material.

5 The total amount of silver (from all silver sources) in the photothermographic materials is generally at least 0.002 mol/m² and preferably from about 0.01 to about 0.05 mol/m².

Reducing Agents

10 The reducing agent (or reducing agent composition comprising two or more components) for the source of reducible silver ions can be any material, preferably an organic material, that can reduce silver (I) ion to metallic silver. Conventional photographic developers such as methyl gallate, hydroquinone, substituted hydroquinones, hindered phenols, amidoximes, azines, catechol,
15 pyrogallol, ascorbic acid (and derivatives thereof), leuco dyes and other materials readily apparent to one skilled in the art can be used in this manner as described for example, in U.S. Patent 6,020,117 (Bauer et al.).

 In some instances, the reducing agent composition comprises two or more components such as a hindered phenol developer and a co-developer that
20 can be chosen from the various classes of reducing agents described below. Ternary developer mixtures involving the further addition of contrast enhancing agents are also useful. Such contrast enhancing agents can be chosen from the various classes described below.

 Hindered phenol reducing agents are preferred (alone or in
25 combination with one or more high contrast co-developing agents and co-developer contrast-enhancing agents). These are compounds that contain only one hydroxy group on a given phenyl ring and have at least one additional substituent located *ortho* to the hydroxy group. Hindered phenol developers may contain more than one hydroxy group as long as each hydroxy group is located on
30 different phenyl rings. Hindered phenol developers include, for example, binaphthols (that is dihydroxybinaphthyls), biphenols (that is dihydroxybiphenyls),

bis(hydroxynaphthyl)methanes, bis(hydroxyphenyl)methanes, hindered phenols, and hindered naphthols, each of which may be variously substituted.

Representative binaphthols include, but are not limited to, 1,1'-bi-2-naphthol, 1,1'-bi-4-methyl-2-naphthol, and 6,6'-dibromo-bi-2-naphthol. For additional compounds see U.S. Patent 3,094,417 (Workman) and U.S. Patent 5,262,295 (Tanaka et al.), both incorporated herein by reference.

Representative biphenols include, but are not limited to, 2,2'-dihydroxy-3,3'-di-*t*-butyl-5,5-dimethylbiphenyl, 2,2'-dihydroxy-3,3',5,5'-tetra-*t*-butylbiphenyl, 2,2'-dihydroxy-3,3'-di-*t*-butyl-5,5'-dichlorobiphenyl, 2-(2-hydroxy-3-*t*-butyl-5-methylphenyl)-4-methyl-6-*n*-hexylphenol, 4,4'-dihydroxy-3,3',5,5'-tetra-*t*-butylbiphenyl and 4,4'-dihydroxy-3,3',5,5'-tetramethylbiphenyl. For additional compounds see U.S. Patent 5,262,295 (noted above).

Representative bis(hydroxynaphthyl)methanes include, but are not limited to, 4,4'-methylenebis(2-methyl-1-naphthol). For additional compounds see U.S. Patent 5,262,295 (noted above).

Representative bis(hydroxyphenyl)methanes include, but are not limited to, bis(2-hydroxy-3-*t*-butyl-5-methylphenyl)methane (CAO-5), 1,1'-bis(2-hydroxy-3,5-dimethylphenyl)-3,5,5-trimethylhexane (NONOX™ or PERMANAX™ WSO), 1,1'-bis(3,5-di-*t*-butyl-4-hydroxyphenyl)methane, 2,2'-bis(4-hydroxy-3-methylphenyl)propane, 4,4'-ethylidene-bis(2-*t*-butyl-6-methylphenol), 2,2'-isobutylidene-bis(4,6-dimethylphenol) (LOWINOX™ 221B46), and 2,2'-bis(3,5-dimethyl-4-hydroxyphenyl)propane. For additional compounds see U.S. Patent 5,262,295 (noted above).

Representative hindered phenols include, but are not limited to, 2,6-di-*t*-butylphenol, 2,6-di-*t*-butyl-4-methylphenol, 2,4-di-*t*-butylphenol, 2,6-dichlorophenol, 2,6-dimethylphenol and 2-*t*-butyl-6-methylphenol.

Representative hindered naphthols include, but are not limited to, 1-naphthol, 4-methyl-1-naphthol, 4-methoxy-1-naphthol, 4-chloro-1-naphthol and 2-methyl-1-naphthol. For additional compounds see U.S. Patent 5,262,295 (noted above).

More specific alternative reducing agents that have been disclosed in dry silver systems include amidoximes such as phenylamidoxime, 2-thienylamidoxime and *p*-phenoxyphenylamidoxime, azines (for example, 4-hydroxy-3,5-dimethoxybenzaldehydrazine), a combination of aliphatic carboxylic acid aryl hydrazides and ascorbic acid, such as 2,2'-bis(hydroxymethyl)-propionyl- β -phenylhydrazide in combination with ascorbic acid, a combination of polyhydroxybenzene and hydroxylamine, a reductone and/or a hydrazine [for example, a combination of hydroquinone and bis(ethoxyethyl)hydroxylamine], piperidino-hexose reductone or formyl-4-methylphenylhydrazine, hydroxamic acids (such as phenylhydroxamic acid, *p*-hydroxyphenylhydroxamic acid, and *o*-alanine-hydroxamic acid), a combination of azines and sulfonamidophenols (for example, phenothiazine and 2,6-dichloro-4-benzenesulfonamidophenol), α -cyanophenylacetic acid derivatives (such as ethyl α -cyano-2-methylphenylacetate and ethyl α -cyanophenylacetate), bis-*o*-naphthols [such as 2,2'-dihydroxyl-1-binaphthyl, 6,6'-dibromo-2,2'-dihydroxy-1,1'-binaphthyl, and bis(2-hydroxy-1-naphthyl)methane], a combination of bis-*o*-naphthol and a 1,3-dihydroxybenzene derivative (for example, 2,4-dihydroxybenzophenone or 2,4-dihydroxyacetophenone), 5-pyrazolones such as 3-methyl-1-phenyl-5-pyrazolone, reductones (such as dimethylaminohexose reductone, anhydrodihydro-aminohexose reductone and anhydrodihydro-piperidone-hexose reductone), sulfonamidophenol reducing agents (such as 2,6-dichloro-4-benzenesulfonamido-phenol, and *p*-benzenesulfonamidophenol), 2-phenylindane-1,3-dione and similar compounds, chromans (such as 2,2-dimethyl-7-*t*-butyl-6-hydroxychroman), 1,4-dihydropyridines (such as 2,6-dimethoxy-3,5-dicarbethoxy-1,4-dihydropyridine), ascorbic acid derivatives (such as 1-ascorbylpalmitate, ascorbylstearate and unsaturated aldehydes and ketones), 3-pyrazolidones, and certain indane-1,3-diones.

An additional class of reducing agents that can be used as developers are substituted hydrazines including the sulfonyl hydrazides described in U.S. Patent 5,464,738 (Lynch et al.). Still other useful reducing agents are described for example, in U.S. Patent 3,074,809 (Owen), U.S. Patent 3,094,417 (Workman), U.S. Patent 3,080,254 (Grant, Jr.) and U.S. Patent 3,887,417 (Klein et

al.). Auxiliary reducing agents may be useful as described in U.S. Patent 5,981,151 (Leenders et al.). All of these patents are incorporated herein by reference.

Useful co-developer reducing agents can also be used as described
5 for example, in copending U.S. Serial No. 09/239,182 (filed January 28, 1999 by Lynch and Skoog), incorporated herein by reference. Examples of these compounds include, but are not limited to, 2,5-dioxo-cyclopentane carboxaldehydes, 5-(hydroxymethylene)-2,2-dimethyl-1,3-dioxane-4,6-diones, 5-(hydroxymethylene)-1,3-dialkylbarbituric acids, and 2-(ethoxymethylene)-
10 1H-indene-1,3(2H)-diones.

Additional classes of reducing agents that can be used as co-developers are trityl hydrazides and formyl phenyl hydrazides as described in U.S. Patent 5,496,695 (Simpson et al.), 2-substituted malondialdehyde compounds as described in U.S. Patent 5,654,130 (Murray), and 4-substituted isoxazole
15 compounds as described in U.S. Patent 5,705,324 (Murray). Additional developers are described in U.S. Patent 6,100,022 (Inoue et al.). All of the patents above are incorporated herein by reference.

Yet another class of co-developers includes substituted acrylonitrile compounds that are described in U.S. Patent 5,635,339 (Murray) and U.S. Patent
20 5,545,515 (Murray et al.), both incorporated herein by reference. Examples of such compounds include, but are not limited to, the compounds identified as HET-01 and HET-02 in U.S. Patent 5,635,339 (noted above) and CN-01 through CN-13 in U.S. Patent 5,545,515 (noted above). Particularly useful compounds of this type are (hydroxymethylene)cyanoacetates and their metal salts.

25 Various contrast enhancers can be used in some photothermographic materials with specific co-developers. Examples of useful contrast enhancers include, but are not limited to, hydroxylamines (including hydroxylamine and alkyl- and aryl-substituted derivatives thereof), alkanolamines and ammonium phthalamate compounds as described for example, in U.S. Patent
30 5,545,505 (Simpson), hydroxamic acid compounds as described for example, in U.S. Patent 5,545,507 (Simpson et al.), N-acylhydrazine compounds as described

for example, in U.S. Patent 5,558,983 (Simpson et al.), and hydrogen atom donor compounds as described in U.S. Patent 5,637,449 (Harring et al.). All of the above patents are incorporated herein by reference.

5 The reducing agent (or mixture thereof) described herein is generally present as 1 to 10% (dry weight) of the emulsion layer. In multilayer constructions, if the reducing agent is added to a layer other than an emulsion layer, slightly higher proportions, of from about 2 to 15 weight % may be more desirable. Any co-developers may be present generally in an amount of from about 0.001% to about 1.5% (dry weight) of the emulsion layer coating.

10 For color imaging materials (for example, monochrome, dichrome, or full color images), one or more reducing agents can be used that can be oxidized directly or indirectly to form or release one or more dyes.

 The dye-forming or releasing compound may be any colored, colorless, or lightly colored compound that can be oxidized to a colored form, or
15 to release a preformed dye when heated, preferably to a temperature of from about 80°C to about 250°C for a duration of at least 1 second. When used with a dye- or image-receiving layer, the dye can diffuse through the imaging layers and interlayers into the image-receiving layer of the photothermographic material.

 Leuco dyes or "blocked" leuco dyes are one class of dye-forming
20 compounds (or "blocked" dye-forming compounds) that form and release a dye upon oxidation by silver ion to form a visible color image in the practice of the present invention. Leuco dyes are the reduced form of dyes that are generally colorless or very lightly colored in the visible region (optical density of less than 0.2). Thus, oxidation provides a color change that is from colorless to colored, an
25 optical density increase of at least 0.2 units, or a substantial change in hue.

 Representative classes of useful leuco dyes include, but are not limited to, chromogenic leuco dyes (such as indoaniline, indophenol, or azomethine dyes), imidazole leuco dyes such as 2-(3,5-di-*t*-butyl-4-hydroxy-phenyl)-4,5-diphenylimidazole as described for example in U.S. Patent 3,985,565
30 (Gabrielson et al.), dyes having an azine, diazine, oxazine, or thiazine nucleus such as those described for example in U.S. Patent 4,563,415 (Brown et al.), U.S.

Patent 4,622,395 (Bellus et al.), U.S. Patent 4,710,570 (Thien), and U.S. Patent 4,782,010 (Mader et al.), and benzylidene leuco compounds as described for example in U.S. Patent 4,923,792 (Grieve et al.), all incorporated herein by reference. Further details about the chromogenic leuco dyes noted above can be
5 obtained from U.S. Patent 5,491,059 (noted above, Column 13) and references noted therein.

Another useful class of leuco dyes are what are known as “aldazine” and “ketazine” leuco dyes that are described for example in U.S. Patent 4,587,211 (Ishida et al.) and U.S. Patent 4,795,697 (Vogel et al.), both
10 incorporated herein by reference.

Still another useful class of dye-releasing compounds are those that release diffusible dyes upon oxidation. These are known as preformed dye release (PDR) or redox dye release (RDR) compounds. In such compounds, the reducing agents release a mobile preformed dye upon oxidation. Examples of such
15 compounds are described in U.S. Patent 4,981,775 (Swain), incorporated herein by reference.

Further, other useful image-forming compounds are those in which the mobility of a dye moiety changes as a result of an oxidation-reduction reaction with silver halide, or a nonphotosensitive silver salt at high temperature, as
20 described for example in JP Kokai 165,054/84.

Still further, the reducing agent can be a compound that releases a conventional photographic dye forming color coupler or developer upon oxidation as is known in the photographic art.

The dyes that are formed or released can be in the same or different
25 imaging layers. A difference of at least 60 nm in reflective maximum absorbance is preferred. More preferably, this difference is from about 80 to about 100 nm. Further details about the various dye absorbances are provided in U.S. Patent 5,491,059 (noted above, Col. 14).

The total amount of one or more dye- forming or releasing
30 compound that can be incorporated into the photothermographic materials of this invention is generally from about 0.5 to about 25 weight % of the total weight of

each imaging layer in which they are located. Preferably, the amount in each imaging layer is from about 1 to about 10 weight %, based on the total dry layer weight. The useful relative proportions of the leuco dyes would be readily known to a skilled worker in the art.

5

Radiation Absorbing Compounds

It is essential that the one or more thermally-developable imaging layers present in the photothermographic materials of this invention include one or more radiation absorbing compounds to provide a combined (or total) absorbance in the imaging layer(s) of greater than 0.6 (preferably 1 or more) at the exposing wavelength. The upper limit of absorbance is generally 3 (preferably 2). Another term for “absorbance” is optical density. The desired absorbance can also be provided by radiation absorbing compounds that are incorporated into non-imaging layers that are disposed over the thermally-developable imaging layers as long as the radiation absorbing compounds can diffuse into the thermally-developable imaging layers prior to or during coating operations.

15

Absorbance can be determined using the procedures described in U.S. Patent 5,922,529 (Tsuzuki et al.), Col. 47, incorporated herein by reference.

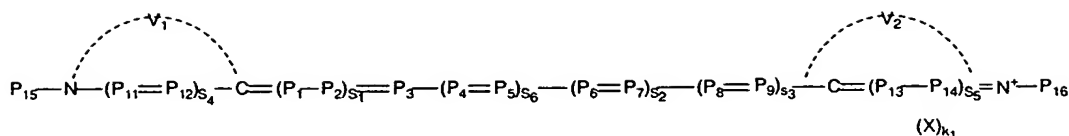
In general, a skilled worker can determine with routine experimentation how much of a given radiation absorbing compound (or mixture of compounds) should be used to provide the desired absorbance. Usually, this amount is at least 10^{-6} mol/m², and preferably it is from about 10^{-5} to about 10^{-3} mol/m².

20

The desired level of absorbance can be provided by the addition of one or more radiation absorbing compounds from one or more classes of dye compounds.

25

One class of dyes useful as radiation absorbing compounds in this invention, are cyanine dyes that can be represented by the following Structure I.



I

wherein V₁ and V₂ independently represent the non-metallic atoms necessary to
 5 form substituted or unsubstituted 5-, 6-, or 7-membered heterocyclic rings, P₁₅ and
 P₁₆ independently represent alkyl, aryl, alkaryl, or heterocycl groups, P₁, P₂, P₃, P₄,
 P₅, P₆, P₇, P₈, P₉, P₁₁, P₁₂, P₁₃, and P₁₄ independently represent substituted or
 unsubstituted methine groups that may optionally form a ring with one or more
 other methine groups or with an auxochrome, s₁, s₂, s₃, s₄, s₅ and s₆ are
 10 independently equal to 0 or 1, X is an electric charge neutralizing counterion, and
 k₁ is an integer inclusive of 0 necessary to neutralize an electric charge in the
 molecule.

V₁ and V₂ independently represent the non-metallic atoms
 necessary to form substituted or unsubstituted 5-, 6-, or 7-membered heterocyclic
 15 rings that may also include in addition to the hetero nitrogen atom, a second hetero
 atom such as a second nitrogen, oxygen, selenium, or sulfur atom. V₁ and V₂ also
 may be further substituted, for example, to form additional rings fused to the
 heterocyclic nucleus, and have additional substituents attached thereon.

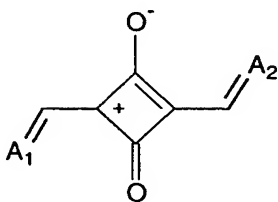
In a preferred embodiment the substituted methine groups
 20 represented by P₁, P₂, P₃, P₄, P₅, P₆, P₇, P₈, P₉, P₁₁, P₁₂, P₁₃, and P₁₄ may be further
 substituted with substituted or unsubstituted alkyl groups of up to 20 carbon
 atoms, substituted or unsubstituted aryl groups of up to 20 carbon atoms, halogen
 atoms (F, Cl, Br, and I), substituted or unsubstituted alkoxy, aryloxy, alkylthio, or
 arylthio groups of up to 20 carbon atoms (such as methoxy, ethoxy, phenoxy,
 25 thiomethyl, thioethyl, or thiophenyl), substituted or unsubstituted alkoxyalkylene
 groups, substituted or unsubstituted alkylthioalkylene groups (such as methoxy-
 ethylene and ethylthioethylene), primary, secondary, and tertiary amino groups of
 up to 20 carbon atoms, substituted or unsubstituted heterocyclic ring groups

comprising up to 6 ring atoms, substituted or unsubstituted carbocyclic ring groups comprising up to 6 ring carbon atoms, and substituted or unsubstituted fused ring and bridging groups comprising up to 14 ring atoms.

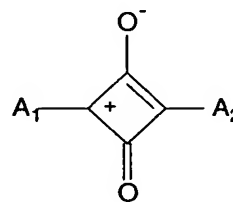
In another preferred embodiment, the methine groups represented by P₁, P₂, P₃, P₄, P₅, P₆, P₇, P₈, and P₉, are independently substituted with alkyl or alkoxy groups of up to 6 carbon atoms, or are joined to form one or more substituted or unsubstituted 5-, 6-, or 7-membered rings, or two or more fused substituted or unsubstituted 5-, 6-, or 7-membered rings.

Preferably, P₁₅ and P₁₆ are independently substituted or unsubstituted alkyl groups having 1 to 10 carbon atoms (such as methyl, ethyl, *n*-propyl, *iso*-propyl, *n*-hexyl, benzyl, *n*-butyl, alkylcarboxy groups, carboxyethyl, carboxybutyl, sulfobutyl, and sulfopropyl), substituted or unsubstituted aralkyl groups (such as benzyl and diphenylmethyl groups), or substituted or unsubstituted aryl groups having 6 to 10 carbon atoms in the aromatic ring system (such as phenyl, naphthyl, *p*-methylphenyl, 2,4-diethylphenyl, 2,4-dimethylphenyl, *p*-chlorophenyl, and 3-methoxyphenyl groups). Other useful alkyl and aryl groups would be readily apparent to one skilled in the art. More preferably, P₁₅ and P₁₆ are independently substituted or unsubstituted alkyl groups having 1 to 6 carbon atoms, and even more preferably, P₁₅ and P₁₆ are independently substituted or unsubstituted methyl, ethyl, *n*-propyl, or *n*-butyl groups, or alkylcarboxy groups.

Another class of dyes useful as radiation absorbing compounds in this invention, are dyes that can be represented by the following Structures II and III.



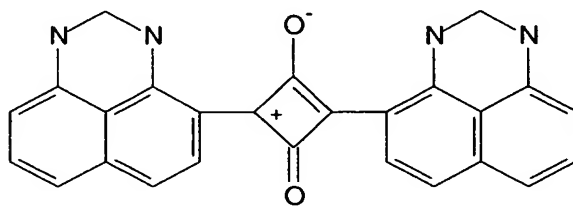
II



III

wherein A₁ and A₂ independently represent a group derived from a dye base, a heterocyclic group, or an electron-donating aromatic group. Squaraine dyes are well-known materials and can be prepared with a variety of substituents [see for example U.S. Patent 6,316,081 (Nelson et al.) and H. E. Sprenger and
5 W. Ziegenbein, *Angew. Chem. Internat. Ed.*, **1968**, 7, 530-535].

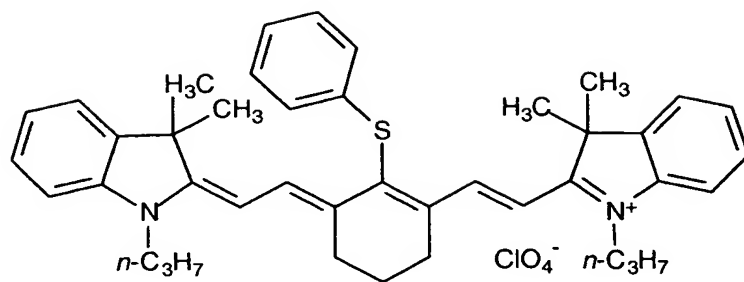
One particularly useful class of squaraine dyes are dihydro-perimidine squaraine dyes having the nucleus represented by the following Structure IV:



IV

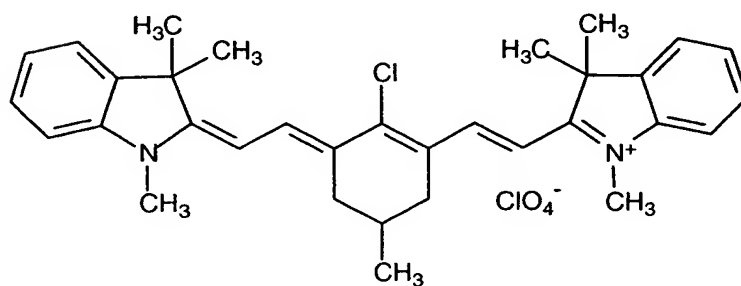
Details of such dyes having the dihydroperimidine squaraine nucleus and methods of their preparation can be found in U.S. Patent 6,063,560 (Suzuki et al.), U.S.
15 Patent 5,380,635 (Gomez et al.), and EP 0 748 465B1 [counterpart to U.S. Patent 5,380,635 (Gomez, et al.)], all incorporated herein by reference. As one skilled in the art would understand, the nitrogen atoms shown in Structure I have an open valence and can be unsubstituted or substituted with various substituents (the same or different on each nitrogen) including but not limited to, substituted or
20 unsubstituted alkyl groups having 1 to 20 carbon atoms, substituted or unsubstituted cycloalkyl groups having 4 to 20 carbon atoms in the ring system, or substituted or unsubstituted aryl groups having 6 to 14 carbon atoms in the ring system. Alternatively, the substituent on a nitrogen atom can be joined to an adjacent nitrogen atom or to the adjacent carbon atom to form 5-, 6-, or 7-
25 membered heterocyclic rings.

Representative radiation absorbing compounds are the following Compounds AD-1 to AD-55. These compounds may be used alone or in mixtures.

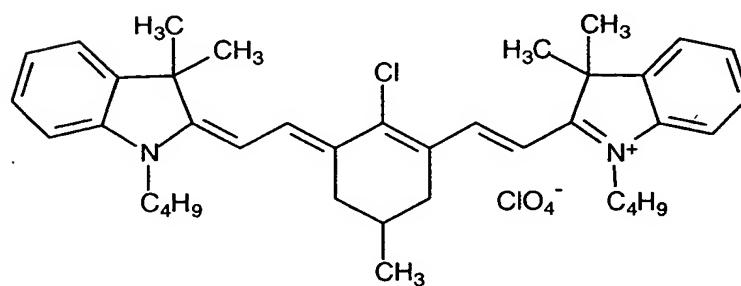


AD-1

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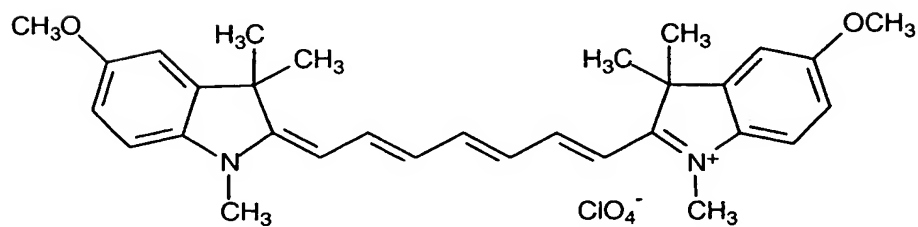


AD-2



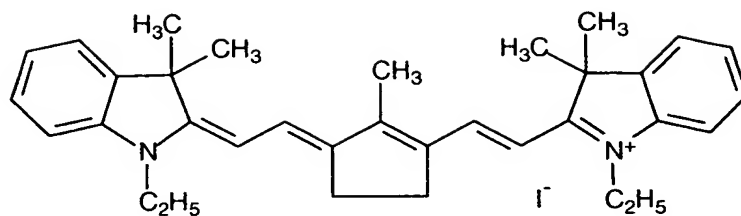
AD-3

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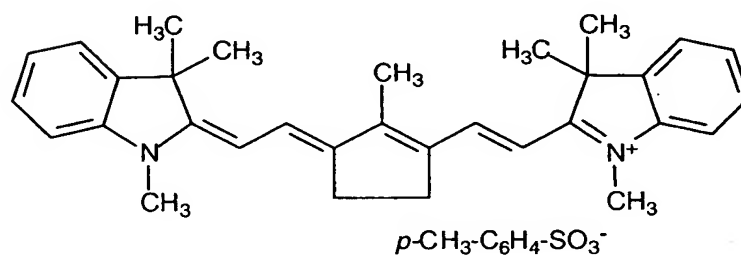
AD-4

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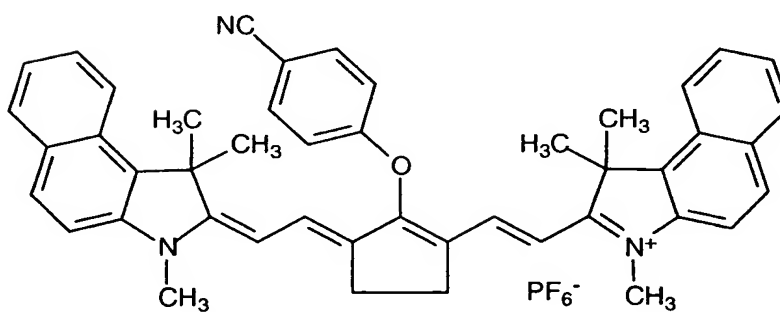
AD-5

5



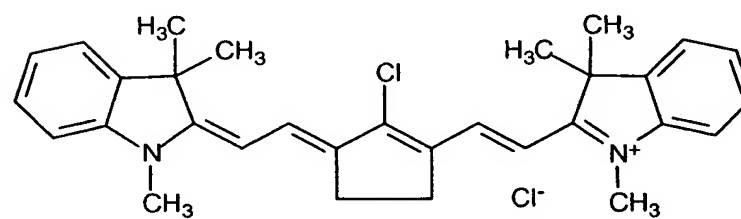
AD-6

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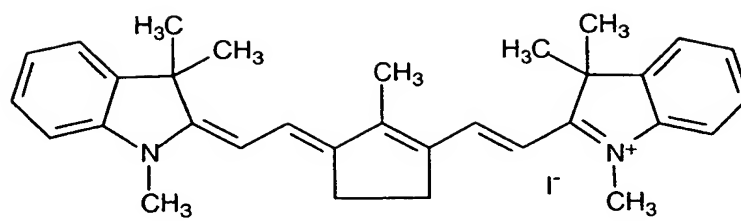


AD-7

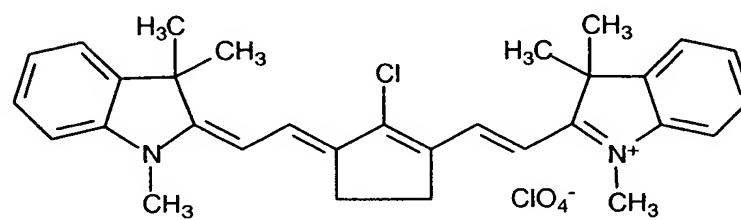
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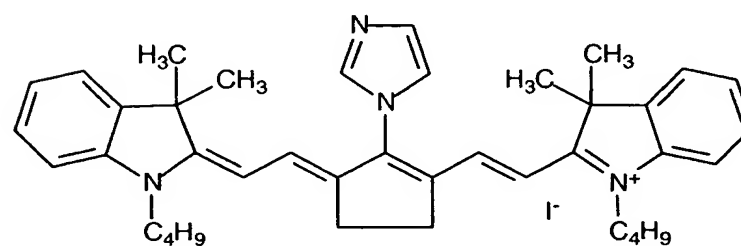
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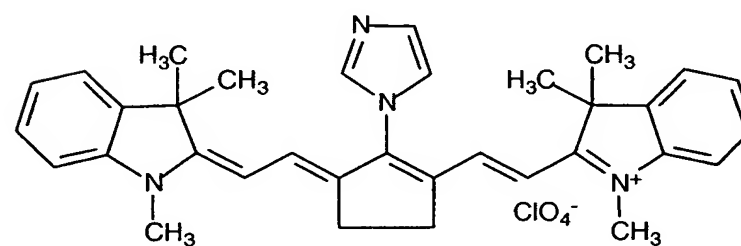
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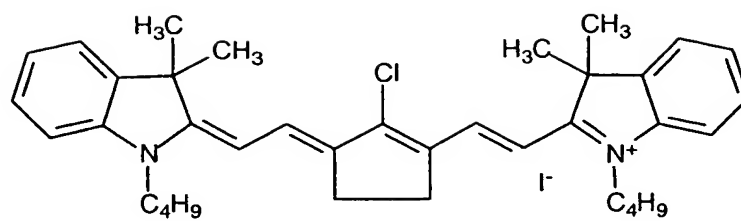
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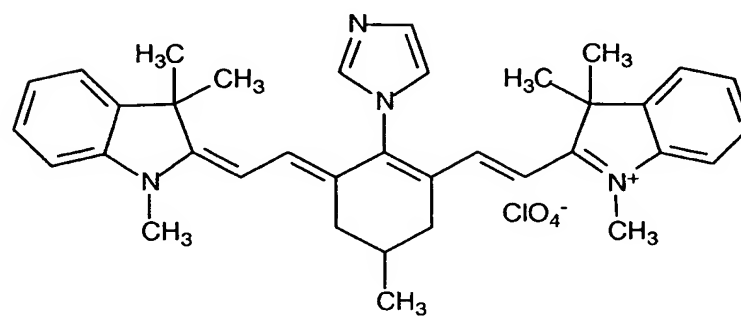
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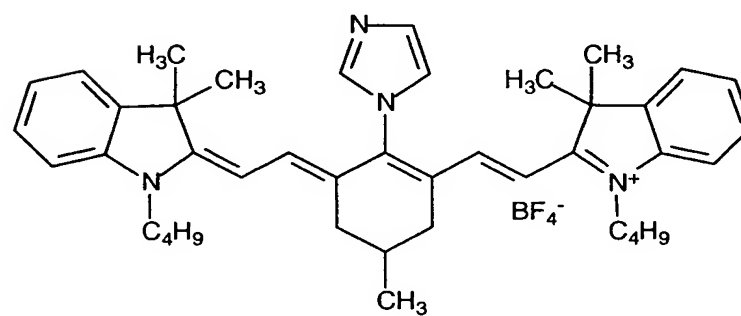
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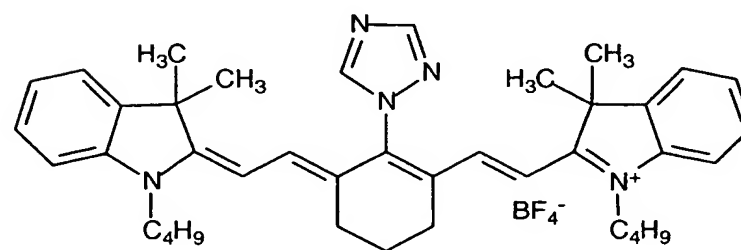
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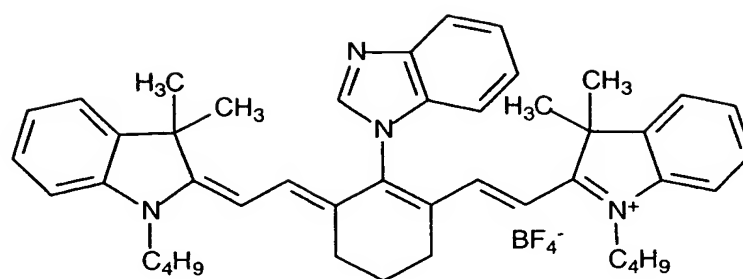
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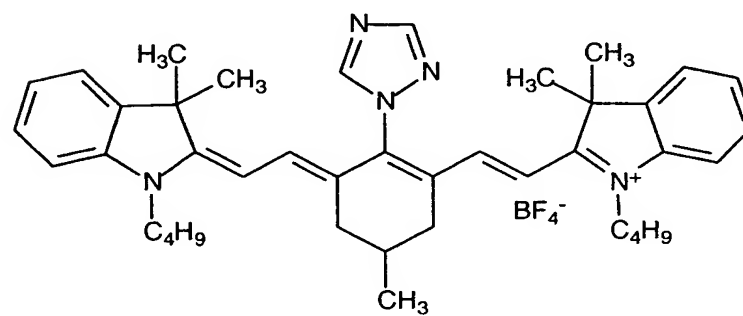
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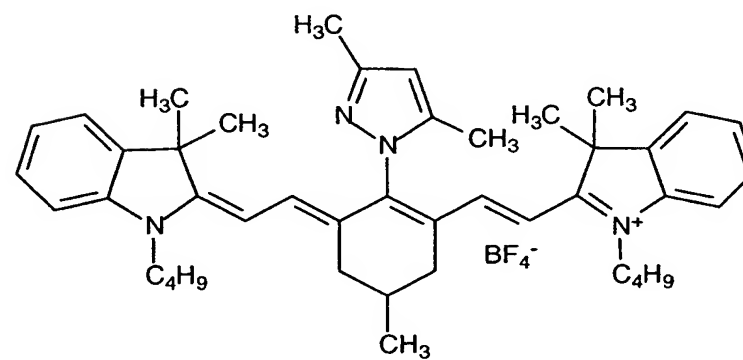
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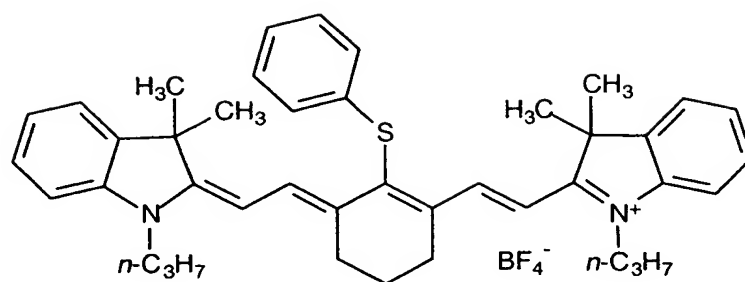
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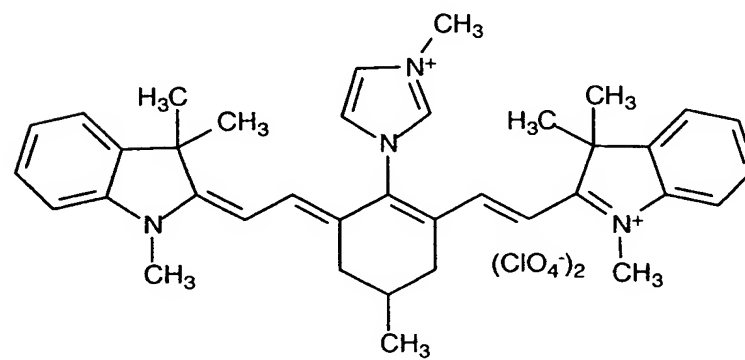
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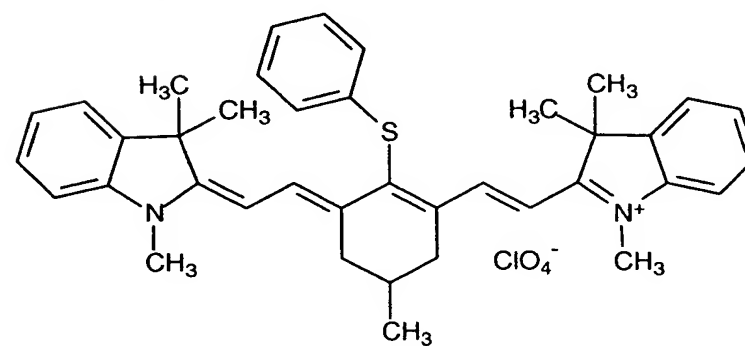
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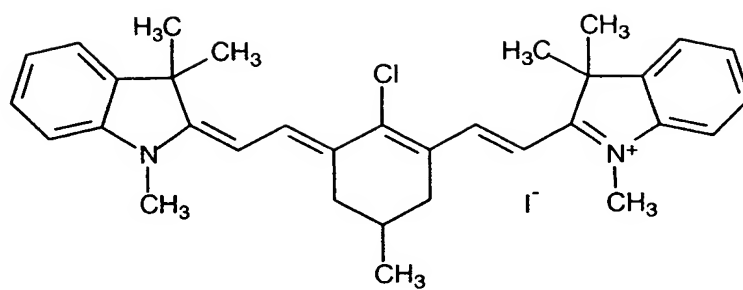
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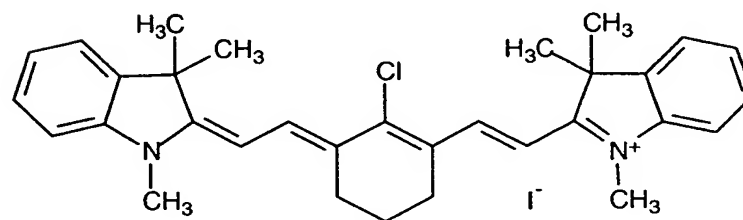
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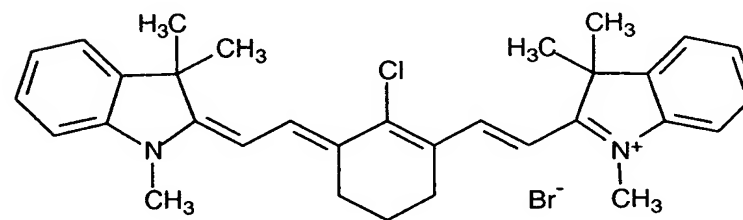
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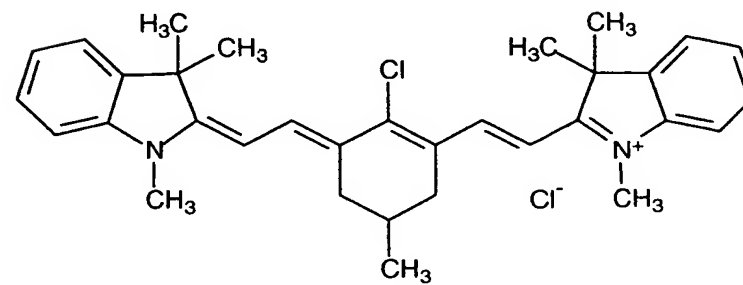
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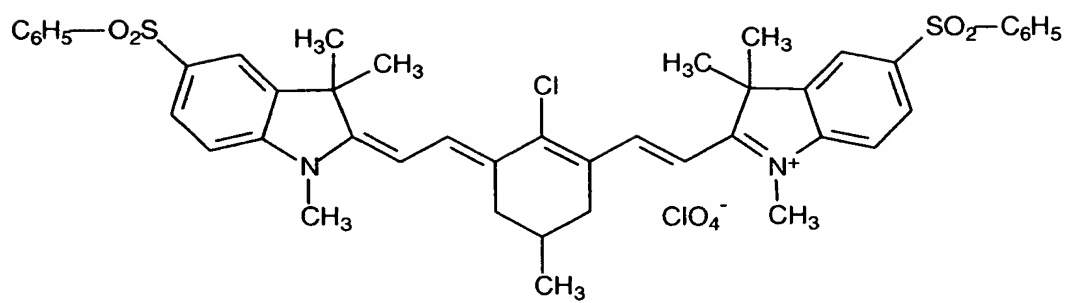
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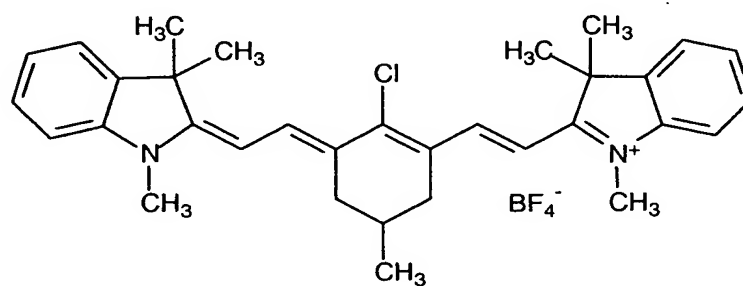
AD-25



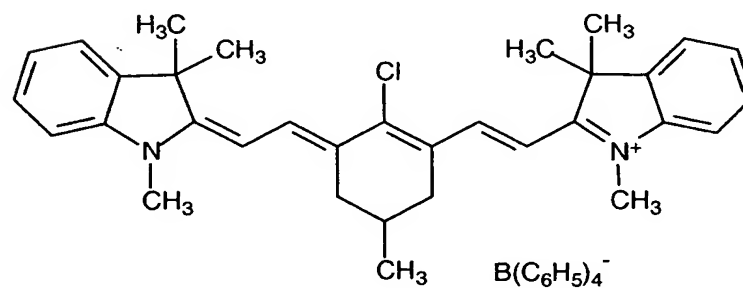
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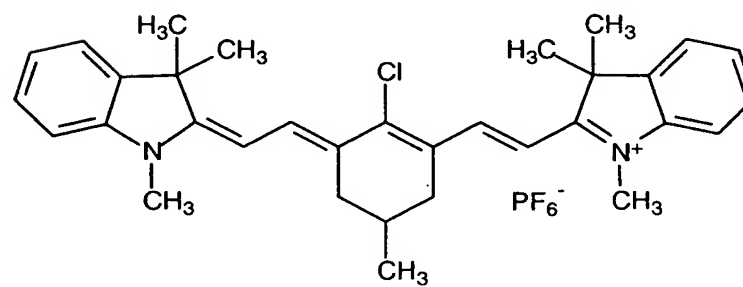
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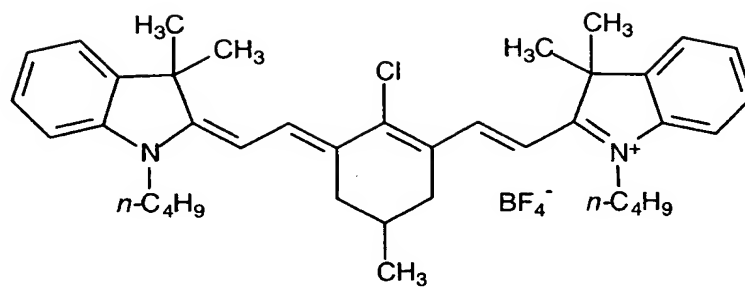
AD-28



AD-29

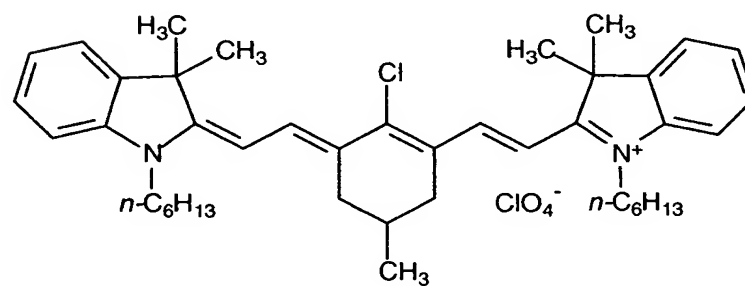


AD-30

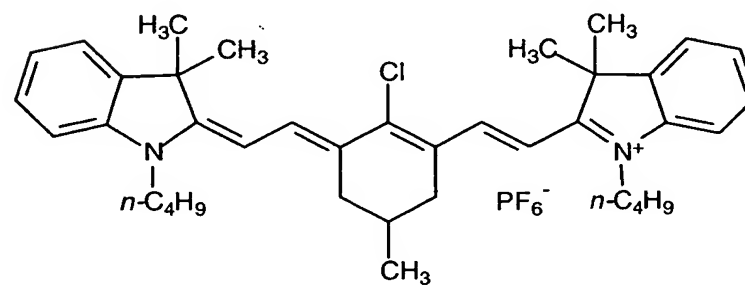


AD-31

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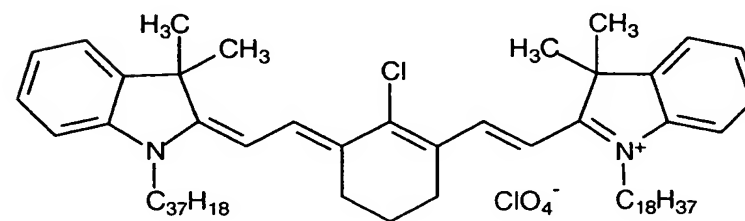


AD-32



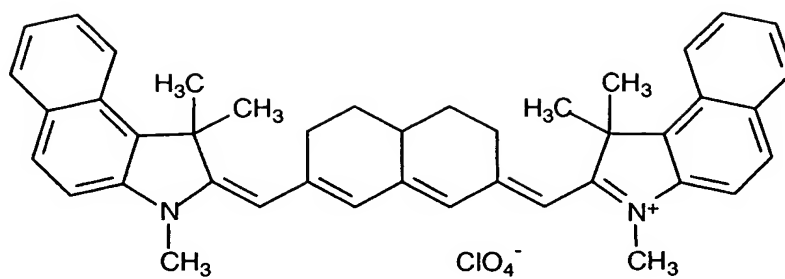
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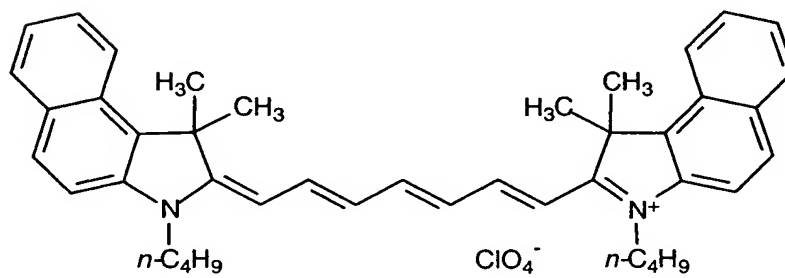


AD-34

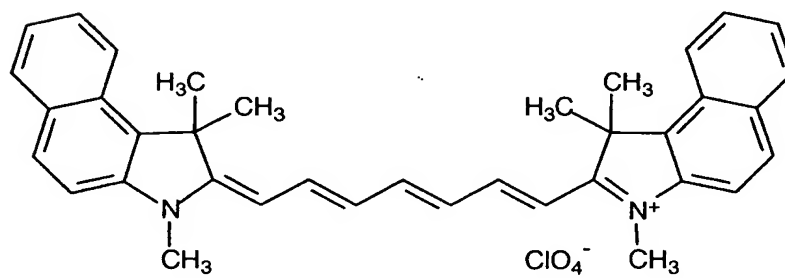
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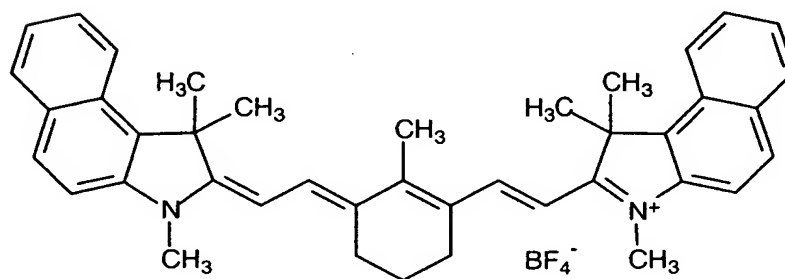
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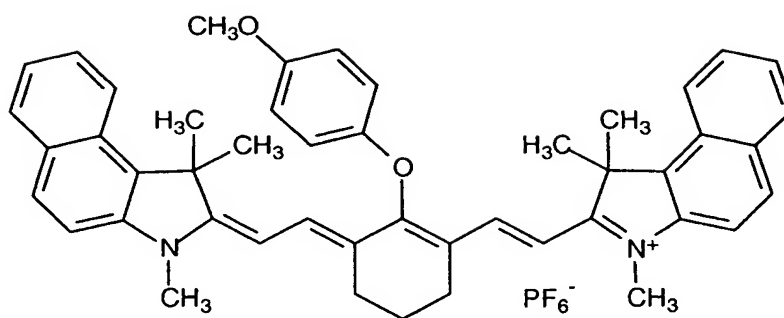
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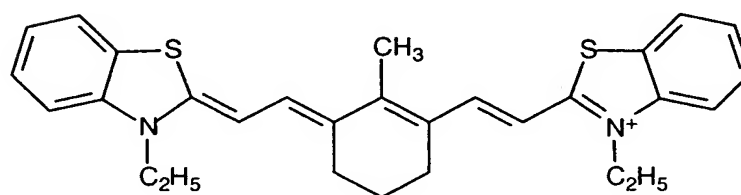
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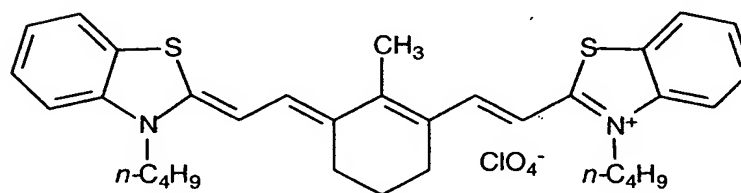
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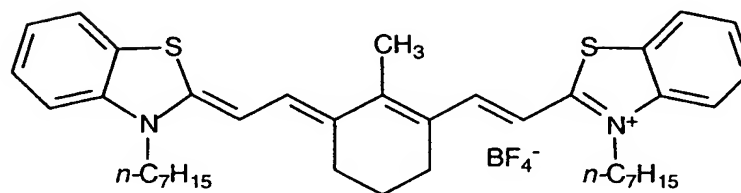
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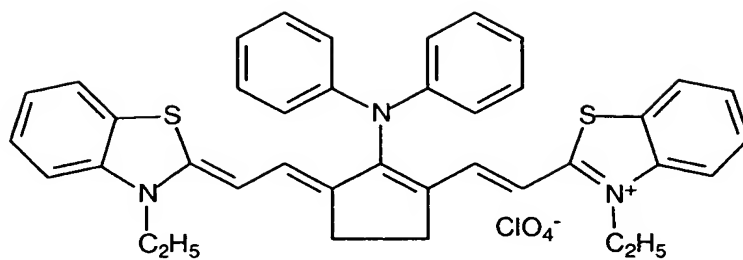
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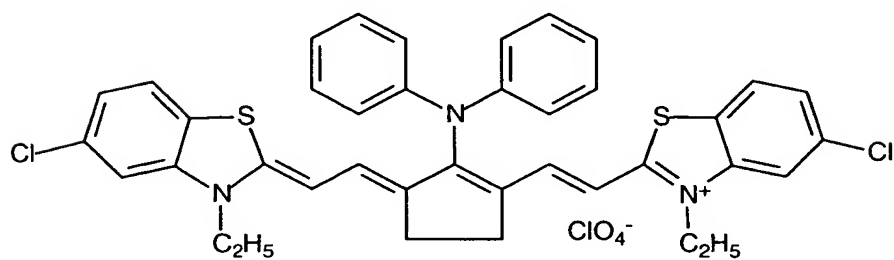
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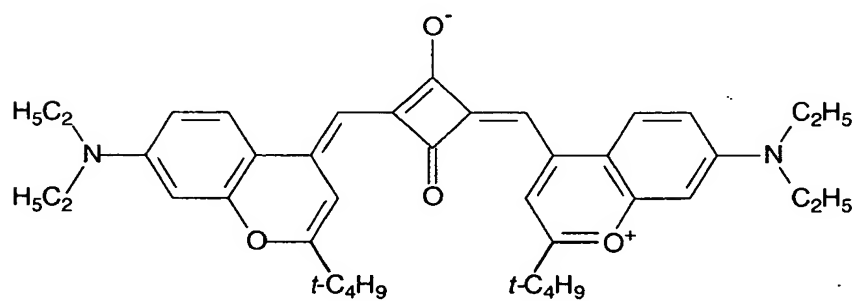
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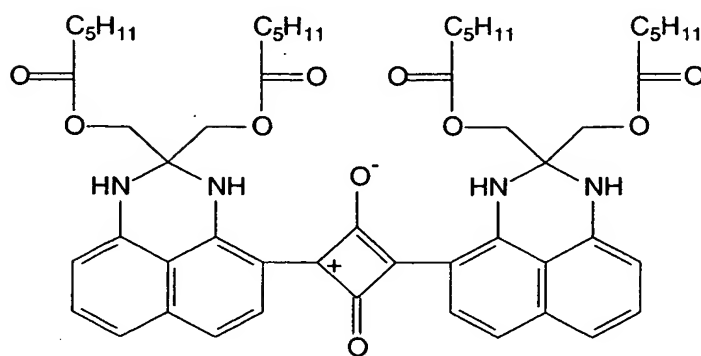
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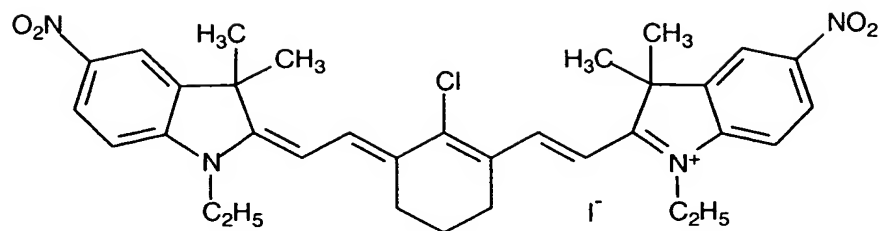
AD-44



AD-45

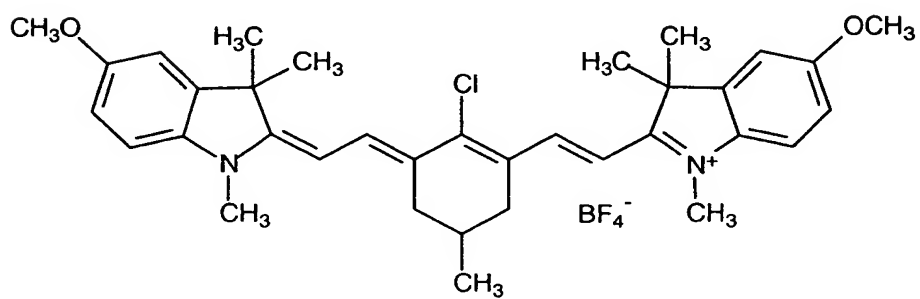


AD-46



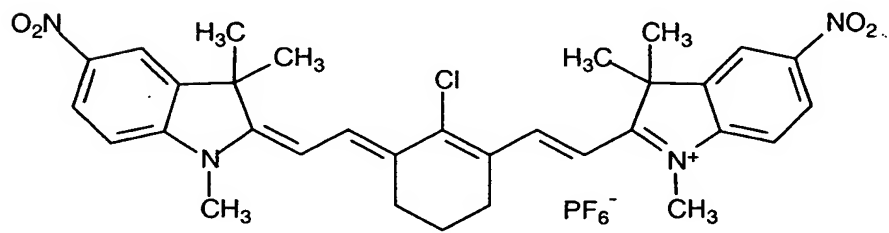
AD-47

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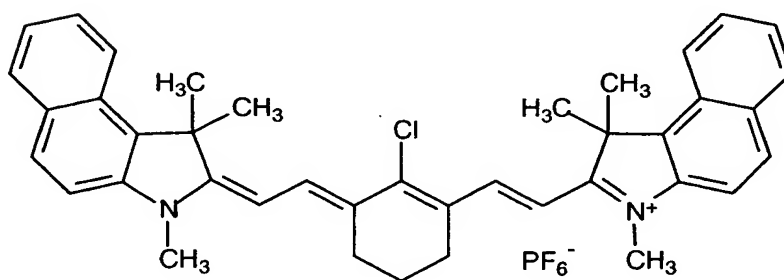


AD-48

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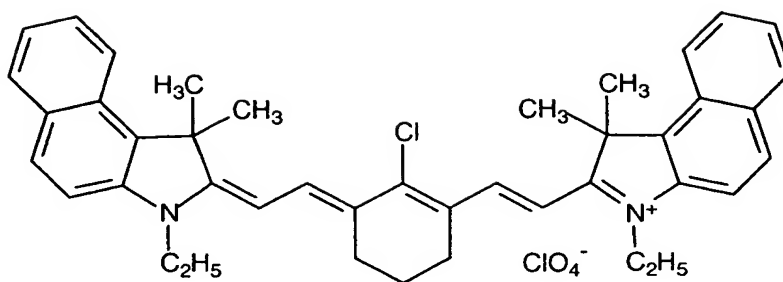


AD-49

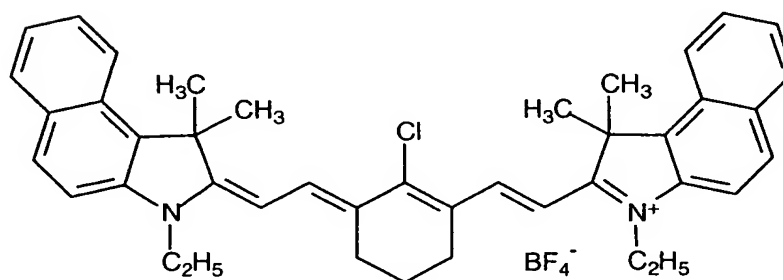


AD-50

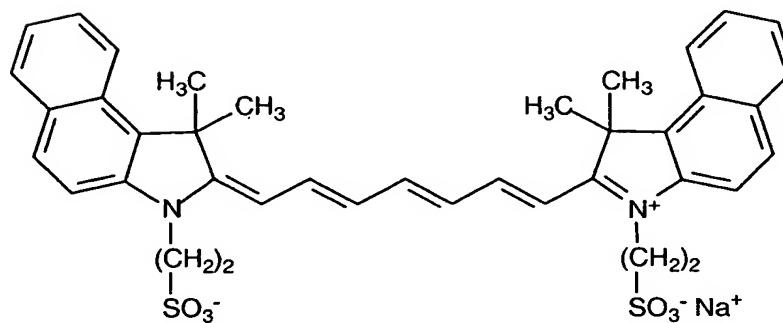
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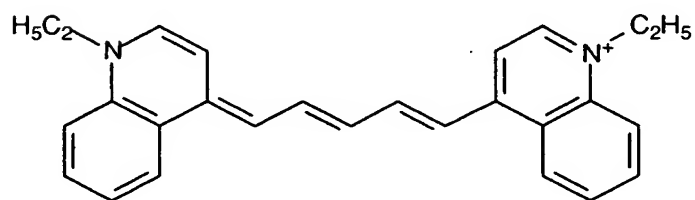
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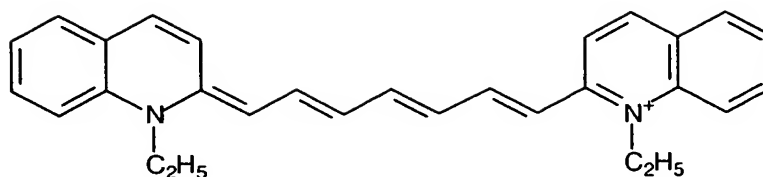
AD-52



AD-53



AD-54



AD-55

The various radiation absorbing compounds useful in the practice of the present invention can be obtained from a number of commercial sources, or prepared using procedures that are well known in the art, including those procedures described for example in EP-A-0 342 810 (Leichter) and U.S. Patent 5,541,054(noted above) for benzothiazole dyes as well as those described in, for example, F. M. Hamer, *Cyanine Dyes and Related Compounds*, John Wiley & Sons, New York, 1964, K. Venkataraman, *The Chemistry of Synthetic Dyes*, Academic Press, New York, Volume II, Chapter XXXVIII, pp. 1143-1186, G. and E. Ficken, *The Chemistry of Synthetic Dyes*, K. Venkataraman, Ed., Academic Press, New York, 1971, Volume IV, Chapter V, pp. 211-340, and references cited therein.

In addition, the desired level of absorbance can be provided by the addition of one or more radiation absorbing compounds from other classes of dye compounds, for example cyanines, hemicyanines, merocyanines, and oxanols.

Other Addenda

The photothermographic materials of the invention can also contain other additives such as shelf-life stabilizers, toners, antifoggants, contrast enhancers, development accelerators, acutance dyes, post-processing stabilizers or stabilizer precursors, and other image-modifying agents as would be readily apparent to one skilled in the art.

To further control the properties of photothermographic materials, (for example, contrast, D_{\min} , speed, or fog), it may be preferable to add one or more heteroaromatic mercapto compounds or heteroaromatic disulfide compounds of the formulae: Ar-S-M and Ar-S-S-Ar, wherein M represents a hydrogen atom or an alkali metal atom and Ar represents a heteroaromatic ring or fused

heteroaromatic ring containing one or more of nitrogen, sulfur, oxygen, selenium, or tellurium atoms. Preferably, the heteroaromatic ring comprises benzimidazole, naphthimidazole, benzothiazole, naphthothiazole, benzoxazole, naphthoxazole, benzoselenazole, benzotellurazole, imidazole, oxazole, pyrazole, triazole, thiazole, thiadiazole, tetrazole, triazine, pyrimidine, pyridazine, pyrazine, pyridine, purine, quinoline, or quinazolinone. Compounds having other heteroaromatic rings and compounds providing enhanced sensitization at other wavelengths are also envisioned to be suitable. For example, heteroaromatic mercapto compounds are described as supersensitizers for infrared photothermographic materials in EP-A-0 559 228. (Philip Jr. et al.).

The heteroaromatic ring may also carry substituents. Examples of preferred substituents are halo groups (such as bromo and chloro), hydroxy, amino, carboxy, alkyl groups (for example, of 1 or more carbon atoms and preferably 1 to 4 carbon atoms), and alkoxy groups (for example, of 1 or more carbon atoms and preferably of 1 to 4 carbon atoms).

Heteroaromatic mercapto compounds are most preferred. Examples of preferred heteroaromatic mercapto compounds are 2-mercaptobenzimidazole, 2-mercapto-5-methylbenzimidazole, 2-mercaptobenzothiazole and 2-mercaptobenzoxazole, and mixtures thereof.

If used, a heteroaromatic mercapto compound is generally present in an emulsion layer in an amount of at least about 0.0001 mole per mole of total silver in the emulsion layer. More preferably, the heteroaromatic mercapto compound is present within a range of about 0.001 mole to about 1.0 mole, and most preferably, about 0.005 mole to about 0.2 mole, per mole of total silver.

The photothermographic materials of the present invention can be further protected against the production of fog and can be stabilized against loss of sensitivity during storage. While not necessary for the practice of the invention, it may be advantageous to add mercury(II) salts to the emulsion layer(s) as an antifoggant. Preferred mercury(II) salts for this purpose are mercuric acetate and mercuric bromide. Other useful mercury salts include those described in U.S. Patent 2,728,663 (Allen).

Other suitable antifoggants and stabilizers that can be used alone or in combination include thiazolium salts as described in U.S. Patent 2,131,038 (Staud) and U.S. Patent 2,694,716 (Allen), azaindenes as described in U.S. Patent 2,886,437 (Piper), triazaindolizines as described in U.S. Patent 2,444,605 (Heimbach), the urazoles described in U.S. Patent 3,287,135 (Anderson), sulfocatechols as described in U.S. Patent 3,235,652 (Kennard), the oximes described in GB 623,448 (Carrol et al.), polyvalent metal salts as described in U.S. Patent 2,839,405 (Jones), thiuronium salts as described in U.S. Patent 3,220,839 (Herz), palladium, platinum and gold salts as described in U.S. Patent 2,566,263 (Tirelli) and U.S. Patent 2,597,915 (Damshroder), compounds having -SO₂CB₃ groups as described for example in U.S. Patent 5,594,143 (Kirk et al.) and U.S. Patent 5,374,514 (Kirk et al.), and 2-(tribromomethylsulfonyl)quinoline compounds as described in U.S. Patent 5,460,938 (Kirk et al.).

Stabilizer precursor compounds capable of releasing stabilizers upon application of heat during development can also be used. Such precursor compounds are described in for example, U.S. Patent 5,158,866 (Simpson et al.), U.S. Patent 5,175,081 (Krepeski et al.), U.S. Patent 5,298,390 (Sakizadeh et al.), and U.S. Patent 5,300,420 (Kenney et al.).

In addition, certain substituted-sulfonyl derivatives of benzo-triazoles (for example alkylsulfonylbenzotriazoles and arylsulfonylbenzotriazoles) have been found to be useful stabilizing compounds (such as for post-processing print stabilizing), as described in U.S. Patent 6,171,767 (Kong et al.).

Furthermore, other specific useful antifoggants/stabilizers are described in more detail in U.S. Patent 6,083,681 (Lynch et al.), incorporated herein by reference.

Other antifoggants are hydrobromic acid salts of heterocyclic compounds (such as pyridinium hydrobromide perbromide) as described, for example, in U.S. Patent 5,028,523 (Skoug), benzoyl acid compounds as described, for example, in U.S. Patent 4,784,939 (Pham), substituted propenenitrile compounds as described, for example, in U.S. Patent 5,686,228 (Murray et al.), silyl blocked compounds as described, for example, in U.S. Patent 5,358,843

(Sakizadeh et al.), vinyl sulfones as described, for example, in EP-A-0 600 589 (Philip, Jr. et al.) and EP-A-0 600 586 (Philip, Jr. et al.), and tribromomethylketones as described, for example, in EP-A-0 600 587 (Oliff et al.).

Preferably, the photothermographic materials include one or more
5 polyhalo antifoggants that include one or more polyhalo substituents including but not limited to, dichloro, dibromo, trichloro, and tribromo groups. The antifoggants can be aliphatic, alicyclic, or aromatic compounds, including aromatic heterocyclic and carbocyclic compounds.

Particularly useful antifoggants are polyhalo antifoggants, such as
10 those having a $-\text{SO}_2\text{C}(\text{X}')_3$ group wherein X' represents the same or different halogen atoms.

The use of “toners” or derivatives thereof that improve the image is highly desirable. Preferably, if used, a toner can be present in an amount of about 0.01% by weight to about 10%, and more preferably about 0.1% by weight to
15 about 10% by weight, based on the total dry weight of the layer in which it is included. Toners may be incorporated in the photothermographic emulsion layer or in an adjacent layer. Toners are well known materials in the photothermographic art, as shown in U.S. Patent 3,080,254 (Grant, Jr.), U.S. Patent 3,847,612 (Winslow), U.S. Patent 4,123,282 (Winslow), U.S. Patent 4,082,901 (Laridon et al.), U.S. Patent 3,074,809 (Owen), U.S. Patent 3,446,648 (Workman), U.S. Patent
20 3,844,797 (Willems et al.), U.S. Patent 3,951,660 (Hagemann et al.), U.S. Patent 5,599,647 (Defieuw et al.), and GB 1,439,478 (Agfa-Gevaert).

Examples of toners include, but are not limited to, phthalimide and
25 *N*-hydroxyphthalimide, cyclic imides (such as succinimide), pyrazoline-5-ones, quinazolinone, 1-phenylurazole, 3-phenyl-2-pyrazoline-5-one, and 2,4-thiazolidinedione, naphthalimides (such as *N*-hydroxy-1,8-naphthalimide), cobalt complexes [such as hexaaminecobalt(3+) trifluoroacetate], mercaptans (such as 3-mercapto-1,2,4-triazole, 2,4-dimercaptopyrimidine, 3-mercapto-4,5-diphenyl-1,2,4-triazole and 2,5-dimercapto-1,3,4-thiadiazole), *N*-(aminomethyl)aryldicarboximides [such as (N,N-dimethylaminomethyl)phthalimide, and
30 N-(dimethylaminomethyl)naphthalene-2,3-dicarboximide, a combination of

blocked pyrazoles, isothiuronium derivatives, and certain photobleach agents [such as a combination of N,N'-hexamethylene-bis(1-carbamoyl-3,5-dimethyl-pyrazole), 1,8-(3,6-diazaoctane)bis(isothiuronium)trifluoroacetate, and 2-(tribromomethylsulfonyl benzothiazole)], merocyanine dyes {such as 3-ethyl-
5 5-[(3-ethyl-2-benzothiazolinylidene)-1-methyl-ethylidene]-2-thio-2,4-*o*-azolidine-dione}, phthalazine and derivatives thereof [such as those described in U.S. Patent 6,146,822 (Asanuma et al.)], phthalazinone and phthalazinone derivatives, or metal salts or these derivatives [such as 4-(1-naphthyl)phthalazinone, 6-chlorophthalazinone, 5,7-dimethoxyphthalazinone, and 2,3-dihydro-
10 1,4-phthalazinedione], a combination of phthalazine (or derivative thereof) plus one or more phthalic acid derivatives (such as phthalic acid, 4-methylphthalic acid, 4-nitrophthalic acid, and tetrachlorophthalic anhydride), quinazolinediones, benzoxazine or naphthoxazine derivatives, rhodium complexes functioning not only as tone modifiers but also as sources of halide ion for silver halide formation
15 *in situ* [such as ammonium hexachlororhodate (III), rhodium bromide, rhodium nitrate, and potassium hexachlororhodate (III)], benzoxazine-2,4-diones (such as 1,3-benzoxazine-2,4-dione, 8-methyl-1,3-benzoxazine-2,4-dione and 6-nitro-1,3-benzoxazine-2,4-dione), pyrimidines and asym-triazines (such as 2,4-dihydroxypyrimidine, 2-hydroxy-4-aminopyrimidine and azauracil) and
20 tetraazapentalene derivatives [such as 3,6-dimercapto-1,4-diphenyl-1*H*,4*H*-2,3*a*,5,6*a*-tetraazapentalene and 1,4-di-(*o*-chlorophenyl)-3,6-dimercapto-1*H*,4*H*-2,3*a*,5,6*a*-tetraazapentalene].

Phthalazine and phthalazine derivatives [such as those described in U.S. Patent 6,146,822 (noted above), incorporated herein by reference] are
25 particularly useful toners.

Binders

The photocatalyst (such as photosensitive silver halide), the non-photosensitive source of reducible silver ions, the reducing agent
30 composition, and any other additives used in the present invention are generally added to one or more binders that are either hydrophilic or hydrophobic. Thus,

either aqueous or solvent-based formulations can be used to prepare the photo-thermographic materials of this invention. Mixtures of either or both types of binders can also be used. It is preferred that the binder be selected from hydrophobic polymeric materials, such as, for example, natural and synthetic resins that are sufficiently polar to hold the other ingredients in solution or suspension.

Examples of typical hydrophobic binders include, but are not limited to, polyvinyl acetals, polyvinyl chloride, polyvinyl acetate, cellulose acetate, cellulose acetate butyrate, polyolefins, polyesters, polystyrenes, polyacrylonitrile, polycarbonates, methacrylate copolymers, maleic anhydride ester copolymers, butadiene-styrene copolymers and other materials readily apparent to one skilled in the art. Copolymers (including terpolymers) are also included in the definition of polymers. The polyvinyl acetals (such as polyvinyl butyral and polyvinyl formal) and vinyl copolymers (such as polyvinyl acetate and polyvinyl chloride) are particularly preferred. Particularly suitable binders are polyvinyl butyral resins that are available as BUTVAR™ B79 (Solutia, Inc.) and Pioloform™ BS-18 or Pioloform™ BL-16 (Wacker Chemical Company). Aqueous dispersions (or latexes) of hydrophobic binders may also be used.

Examples of useful hydrophilic binders include, but are not limited to, gelatin and gelatin-like derivatives (hardened or unhardened), cellulosic materials such as hydroxymethyl cellulose, acrylamide/methacrylamide polymers, acrylic/methacrylic acid polymers, polyvinyl pyrrolidones, polyvinyl alcohols and polysaccharides (such as dextrans and starch ethers).

Hardeners for various binders may be present if desired. Useful hardeners are well known and include diisocyanate compounds as described for example, in EP-0 600 586B1 and vinyl sulfone compounds as described in EP-0 600 589B1.

Where the proportions and activities of the photothermographic materials require a particular developing time and temperature, the binder(s) should be able to withstand those conditions. Generally, it is preferred that the binder does not decompose or lose its structural integrity at 120°C for 60 seconds.

It is more preferred that it does not decompose or lose its structural integrity at 177°C for 60 seconds.

The polymer binder(s) is used in an amount sufficient to carry the components dispersed therein. The effective range can be appropriately
5 determined by one skilled in the art. Preferably, a binder is used at a level of about 10% by weight to about 90% by weight, and more preferably at a level of about 20% by weight to about 70% by weight, based on the total dry weight of the layer in which it is included.

10 **Support Materials**

The photothermographic materials of this invention comprise a polymeric support that is preferably a flexible, transparent film that has any desired thickness and is composed of one or more polymeric materials, depending upon their use. The supports are generally transparent (especially if the material is
15 used as a photomask) or at least translucent, but in some instances, opaque supports may be useful. They are required to exhibit dimensional stability during thermal development and to have suitable adhesive properties with overlying layers. Useful polymeric materials for making such supports include, but are not limited to, polyesters (such as polyethylene terephthalate and polyethylene
20 naphthalate), cellulose acetate and other cellulose esters, polyvinyl acetal, polyolefins (such as polyethylene and polypropylene), polycarbonates, and polystyrenes (and polymers of styrene derivatives). Preferred supports are composed of polymers having good heat stability, such as polyesters and polycarbonates. Polyethylene terephthalate film is the most preferred support.
25 Various support materials are described, for example, in *Research Disclosure*, August 1979, item 18431. A method of making dimensionally stable polyester films is described in *Research Disclosure*, September 1999, item 42536.

Opaque supports can also be used, such as dyed polymeric films and resin-coated papers that are stable to high temperatures.

30 Support materials can contain various colorants, pigments, antihalation or acutance dyes if desired. Support materials may be treated using

conventional procedures (such as corona discharge) to improve adhesion of overlying layers, or subbing or other adhesion-promoting layers can be used. Useful subbing layer formulations include those conventionally used for photographic materials such as vinylidene halide polymers.

- 5 Support materials may also be treated or annealed to reduce shrinkage and promote dimensional stability.

Photothermographic Formulations

- 10 The formulation for the photothermographic emulsion layer(s) can be prepared by dissolving and dispersing the binder, the photocatalyst, the non-photosensitive source of reducible silver ions, the reducing composition, and optional addenda in an organic solvent, such as toluene, 2-butanone (methyl ethyl ketone), acetone, or tetrahydrofuran.

- 15 Alternatively, these components can be formulated with a hydrophilic binder in water or water-organic solvent mixtures to provide aqueous-based coating formulations.

- 20 Photothermographic materials of the invention can contain plasticizers and lubricants such as polyalcohols and diols of the type described in U.S. Patent 2,960,404 (Milton et al.), fatty acids or esters such as those described in U.S. Patent 2,588,765 (Robijns) and U.S. Patent 3,121,060 (Duane), and silicone resins such as those described in GB 955,061 (DuPont). The materials can also contain matting agents such as starch, titanium dioxide, zinc oxide, silica, and polymeric beads, including beads of the type described in U.S. Patent 2,992,101 (Jelley et al.) and U.S. Patent 2,701,245 (Lynn). Polymeric fluorinated
25 surfactants may also be useful in one or more layers of the imaging materials for various purposes, such as improving coatability and image density uniformity as described in U.S. Patent 5,468,603 (Kub).

- 30 EP-0 792 476 B1 (Geisler et al.) describes various means of modifying photothermographic materials to reduce what is known as the “woodgrain” effect, or uneven image density. This effect can be reduced or eliminated by several means, including treatment of the support, adding matting

agents to the topcoat, using acutance dyes in certain layers, or other procedures described in the noted publication.

The photothermographic materials of this invention can include antistatic or conducting layers. Such layers may contain soluble salts (for
5 example, chlorides or nitrates), evaporated metal layers, or ionic polymers such as those described in U.S. Patent 2,861,056 (Minsk) and U.S. Patent 3,206,312 (Serman et al.), or insoluble inorganic salts such as those described in U.S. Patent 3,428,451 (Trevoy), electroconductive underlayers such as those described in U.S. Patent 5,310,640 (Markin et al.), electronically-conductive metal antimonate
10 particles such as those described in U.S. Patent 5,368,995 (Christian et al.), and electrically-conductive metal-containing particles dispersed in a polymeric binder such as those described in EP-A-0 678 776 (Melpolder et al.). Other antistatic agents are well known in the art.

The photothermographic materials can be constructed of one or
15 more layers on a support. Single layer materials should contain the photocatalyst, the non-photosensitive source of reducible silver ions, the reducing composition, the binder, as well as optional materials such as toners, acutance dyes, coating aids and other adjuvants.

Two-layer constructions comprising a single imaging layer coating
20 containing all the ingredients and a surface protective topcoat are generally found in the materials of this invention. However, two-layer constructions containing photocatalyst and non-photosensitive source of reducible silver ions in one imaging layer (usually the layer adjacent to the support) and the reducing composition and other ingredients in the second imaging layer or distributed
25 between both layers are also envisioned.

Layers to promote adhesion of one layer to another in photothermo-
graphic materials are also known, as described for example, in U.S. Patent 5,891,610 (Bauer et al.), U.S. Patent 5,804,365 (Bauer et al.), and U.S. Patent 4,741,992 (Przedziecki). Adhesion can also be promoted using specific
30 polymeric adhesive materials as described for example, in U.S. Patent 5,928,857 (Geisler et al.).

Layers to reduce emissions from the film may also be present, including the polymeric barrier layers described in copending U.S. Serial No. 09/728,416 (filed December 1, 2000 by Kenney, Skoug, Ishida, and Wallace), U.S. Serial No. 09/821,983 (filed March 30, 2001 by Bauer, Horch, Miller, Yacobuci, and Ishida), and U.S. Serial Number 09/916,366 (filed July 27, 2001 by Bauer, Horch, Miller, Teegarden, Hunt, and Sakizadeh and entitled “Thermally Developable Imaging Materials Containing Hydroxy-Containing Polymeric Barrier Layer”) all incorporated herein by reference.

Photothermographic formulations described herein can be coated by various coating procedures including wire wound rod coating, dip coating, air knife coating, curtain coating, slide coating, or extrusion coating using hoppers of the type described in U.S. Patent 2,681,294 (Beguin). Layers can be coated one at a time, or two or more layers can be coated simultaneously by the procedures described in U.S. Patent 2,761,791 (Russell), U.S. Patent 4,001,024 (Dittman et al.), U.S. Patent 4,569,863 (Keopke et al.), U.S. Patent 5,340,613 (Hanzalik et al.), U.S. Patent 5,405,740 (LaBelle), U.S. Patent 5,415,993 (Hanzalik et al.), U.S. Patent 5,525,376 (Leonard), U.S. Patent 5,733,608 (Kessel et al.), U.S. Patent 5,849,363 (Yapel et al.), U.S. Patent 5,843,530 (Jerry et al.), U.S. Patent 5,861,195 (Bhave et al.), and GB 837,095 (Ilford). A typical coating gap for the emulsion layer can be from about 10 to about 750 μm , and the layer can be dried in forced air at a temperature of from about 20°C to about 100°C. It is preferred that the thickness of the layer be selected to provide maximum image densities greater than about 0.2, and more preferably, from about 0.5 to 5.0 or more, as measured by a MacBeth Color Densitometer Model TD 504.

The photothermographic materials of this invention are prepared at relatively high coating speeds. That is, whatever coating machine is used (preferably slide, curtain, or slot coating machines), the “web” or support to which one or more coating formulations are being applied is moving (or being conveyed) at a speed of at least 5 meters per minutes, preferably at a speed of at least 25 meters per minute, and more preferably at a speed of 100 meters per minute. Similarly, the coated formulations can be dried while the coated “web” or material

is moving or being conveyed at a speed of at least 5 meters per minute, preferably at a speed of at least 25 meters per minute, and more preferably at a speed of 100 meters per minute. Thus, coating and drying speeds are independent of each other, but preferably they are the same.

5 When the layers are coated simultaneously using various coating techniques, a “carrier” layer formulation comprising a single-phase mixture of the two or more polymers, described above, may be used. Such formulations are described in copending and commonly assigned U.S. Serial No. 09/510,648 (filed February 23, 2000 by Ludemann, LaBelle, Geisler, Warren, Crump, and Bhawe).

10 Preferably, two or more layers are applied to a film support using slide coating. The first layer can be coated on top of the second layer while the second layer is still wet. The first and second fluids used to coat these layers can be the same or different organic solvents (or organic solvent mixtures).

 While the first and second layers can be coated on one side of the film support, a manufacturing method can also include forming on the opposing or
15 backside of said polymeric support, one or more additional layers, including an antihalation layer, an antistatic layer, or a layer containing a matting agent (such as silica), or a combination of such layers. It is also contemplated that the photo-thermographic materials of this invention can include emulsion layers on both
20 sides of the support.

 In preferred embodiments, the photothermographic materials of this invention include a surface protective layer on the same side of the support as the one or more thermally-developable layers, an antihalation layer on the opposite side of the support, or both a surface protective layer and an antihalation layer on
25 their respective sides of the support

 To further promote image sharpness, photothermographic materials according to the present invention can contain one or more layers containing antihalation dyes. These dyes are chosen to have absorption close to the exposure wavelength and are designed to absorb scattered light. One or more antihalation
30 dyes may be incorporated into one or more antihalation layers according to known techniques, as an antihalation backing layer, as an antihalation underlayer, or as an

antihalation overcoat. It is preferred that the photothermographic materials of this invention contain an antihalation coating on the support opposite to the side on which the emulsion and topcoat layers are coated.

Dyes particularly useful as antihalation dyes include

5 dihydroperimidine squaraine dyes having the squaraine nucleus exemplified above in Compound AD-46. One particularly useful dihydroperimidine squaraine dye is cyclobutenediylum, 1,3-bis[2,3-dihydro-2,2-bis[[1-oxohexyl)oxy]methyl]-1H-perimidin-4-yl]-2,4-dihydroxy-, bis(inner salt) that is also shown above as radiation absorbing compound AD-46.

10 The indolenine dyes described above as radiation absorbing compounds can also be used as antihalation dyes in a backside layer of the photothermographic materials.

It is also useful in the present invention to employ antihalation dye systems that will decolorize or bleach with heat during processing. Dyes and
15 constructions employing these types of dyes are described in, for example, U.S. Patent 5,135,842 (Kitchin et al.), U.S. Patent 5,266,452 (Kitchin et al.), U.S. Patent 5,314,795 (Helland et al.), and EP-A-0 911 693 (Sakurada et al.).

Additional heat-bleachable antihalation systems include hexaarylbiimidazoles (HABI's) used in combination with certain oxonol dyes as described
20 for example in copending U.S. Serial No. 09/875,772 (filed June 6, 2001 by Goswami, Ramsden, Zielinski, Baird, Weinstein, Helber, and Lynch), or other dyes described for example in copending U.S. Serial No. 09/944,573 (filed August 31, 2001 by Ramsden and Baird), both incorporated herein by reference.

25 **Imaging/Development**

Generally, the materials of this invention are sensitive to radiation in the range of from about 300 to about 850 nm. Imaging can be achieved by exposing the photothermographic materials to a suitable source of radiation to which they are sensitive (typically some type of radiation or electronic signal),
30 including ultraviolet light, visible light, near infrared radiation, and infrared radiation to provide a latent image.

While the imaging materials of the present invention can be imaged in any suitable manner consistent with the type of material using any suitable imaging source (typically some type of radiation or electronic signal), the following discussion will be directed to the preferred imaging means. Generally, the materials are sensitive to radiation in the range of from about 300 to about 850 nm.

Imaging can be achieved by exposing the photothermographic materials of this invention to a suitable source of radiation to which they are sensitive, including ultraviolet light, visible light, near infrared radiation and infrared radiation to provide a latent image. Suitable exposure means are well known and include laser diodes that emit radiation in the desired region, photodiodes and others described in the art, including *Research Disclosure*, Vol. 389, September 1996, item 38957, (such as sunlight, xenon lamps, infrared lamps, and fluorescent lamps). Particularly useful exposure means uses laser diodes, including laser diodes that are modulated to increase imaging efficiency using what is known as multilongitudinal exposure techniques as described in US-A-5,780,207 (Mohapatra et al.). Other exposure techniques are described in US-A-5,493,327 (McCallum et al.).

In one embodiment, the photothermographic materials of this invention are sensitive to infrared radiation at a wavelength of at least 700 nm, and preferably at a wavelength of from about 750 to about 1400 nm (more preferably from about 750 to about 850 nm). In this embodiment, imaging can be achieved by exposure to any source of infrared radiation, including: an infrared laser, an infrared laser diode, an infrared light-emitting diode, an infrared lamp, or any other infrared radiation source readily apparent to one skilled in the art, and others described in the art, such as in *Research Disclosure*, September, 1996, item 38957.

Thermal development conditions will vary, depending on the construction used but will typically involve heating the imagewise exposed material at a suitably elevated temperature. Thus, the latent image can be developed by heating the exposed material at a moderately elevated temperature of, for example, from about 50°C to about 250°C (preferably from about 80°C to

about 200°C and more preferably from about 100°C to about 200°C) for a sufficient period of time, generally from about 1 to about 120 seconds. Heating can be accomplished using any suitable heating means such as a hot plate, a steam iron, a hot roller or a heating bath.

5 In some methods, the development is carried out in two steps. Thermal development takes place at a higher temperature for a shorter time (for example, at about 150°C for up to 10 seconds), followed by thermal diffusion at a lower temperature (for example, at about 80°C) in the presence of a transfer solvent.

10

Use as a Photomask

 The photothermographic materials of the present invention are sufficiently transmissive in the range of from about 350 to about 450 nm in non-imaged areas to allow their use in a process where there is a subsequent exposure of an ultraviolet or short wavelength visible radiation sensitive imageable medium. For example, imaging the photothermographic material and subsequent development affords a visible image. The heat-developed photothermographic material absorbs ultraviolet or short wavelength visible radiation in the areas where there is a visible image and transmits ultraviolet or short wavelength visible radiation where there is no visible image. The heat-developed material may then be used as a mask and positioned between a source of imaging radiation (such as an ultraviolet or short wavelength visible radiation energy source) and an imageable material that is sensitive to such imaging radiation, such as a photopolymer, diazo material, photoresist, or photosensitive printing plate.

15 Exposing the imageable material to the imaging radiation through the visible image in the exposed and heat-developed photothermographic material provides an image in the imageable material. This process is particularly useful where the imageable medium comprises a printing plate and the photothermographic material serves as an imagesetting film.

20 The present invention also provides a method for the formation of a visible image (usually a black-and-white image) by first exposing to electro-

magnetic radiation and thereafter heating the inventive photothermographic material. In one embodiment, the present invention provides a method comprising:

5 A) imagewise exposing the photothermographic material of this invention to electromagnetic radiation to which the photocatalyst (for example, a photosensitive silver halide) of the material is sensitive, to generate a latent image, and

 B) simultaneously or sequentially, heating the exposed material to develop the latent image into a visible image.

10 This visible image can also be used as a mask for exposure of other photosensitive imageable materials, such as graphic arts films, proofing films, printing plates and circuit board films, that are sensitive to suitable imaging radiation (for example, UV radiation). This can be done by imaging an imageable material (such as a photopolymer, a diazo material, a photoresist, or a photo-
15 sensitive printing plate) through the exposed and heat-developed photothermographic material. Thus, in some other embodiments wherein the photothermographic material comprises a transparent support, the image-forming method further comprises:

 C) positioning the exposed and heat-developed photothermographic
20 material between a source of imaging radiation and an imageable material that is sensitive to the imaging radiation, and

 D) exposing the imageable material to the imaging radiation through the visible image in the exposed and heat-developed photothermographic material to provide an image in the imageable material.

25 The following examples are provided to illustrate the practice of this invention, and are not intended to be limiting in any manner. The examples provide exemplary synthetic and preparatory procedures using the indolenine post-processing stabilizing compounds within the scope of the present invention.

Materials and Methods for the Examples:

All materials used in the following examples are readily available from standard commercial sources, such as Aldrich Chemical Co. (Milwaukee Wisconsin) unless otherwise specified. All percentages are by weight unless
5 otherwise indicated. The following additional terms and materials were used.

ACRYLOID™ A-21 or PARALOID™ A-21 is an acrylic copolymer available from Rohm and Haas (Philadelphia, PA).

CAB 171-15S is a cellulose acetate butyrate resin available from Eastman Chemical Co (Kingsport, TN).

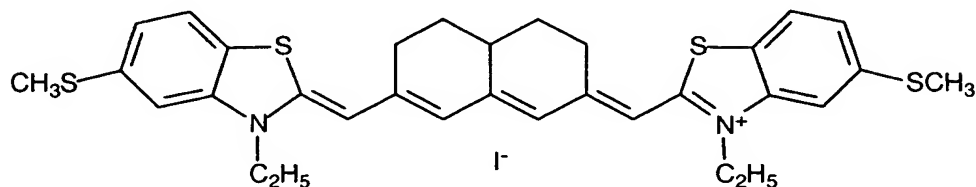
10 DESMODUR™ N3300 is an aliphatic hexamethylene diisocyanate available from Bayer Chemicals (Pittsburgh, PA).

LOWINOX™ 221B446 is 2,2'-isobutylidene-bis(4,6-dimethyl-phenol) available from Great Lakes Chemical (West Lafayette, IN).

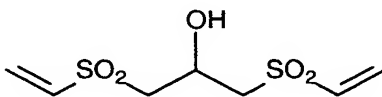
15 PIOLOFORM™ BL-16 and BS-18 are a polyvinyl butyral resins available from Wacker Polymer Systems (Adrian, MI).

MEK is methyl ethyl ketone (or 2-butanone).

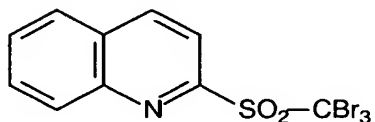
Sensitizing Dye A has the structure shown below.



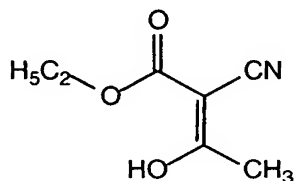
20 Vinyl Sulfone-1 (VS-1) is described in U.S. Patent 6,143,487 and has the structure shown below.



Antifoggant A is 2-(tribromomethylsulfonyl)quinoline and has the structure shown below.



5 Antifoggant B is ethyl-2-cyano-3-oxobutanoate. It is described in U.S. Patent 5,686,228 and has the structure shown below.



Example 1:

10 A photothermographic imaging formulation was prepared as follows:

An emulsion of silver behenate full soap containing preformed silver halide (prepared as described in U.S. Patent 5,939,249, noted above) was homogenized to 28.1% solids in MEK containing Pioloform BS-18 polyvinyl butyral binder (4.4% solids). To 192 parts of this emulsion were added 1.6 parts of a 15% solution of pyridinium hydrobromide perbromide in methanol with stirring. After 60 minutes of mixing, 2.1 parts of an 11% zinc bromide solution in methanol was added. Stirring was continued and after 30 minutes, an addition to was made of a solution of 0.15 parts 2-mercapto-5-methylbenzimidazole, 0.007 parts Sensitizing Dye A, 1.7 parts of 2-(4-chlorobenzoyl)benzoic acid, 10.8 parts of methanol, and 3.8 parts of MEK.

After stirring for another 75 minutes, 41 parts of Pioloform BL-16 was added and the temperature was reduced to 10°C, and mixing was continued for another 30 minutes.

25 At this time, the photothermographic imaging formulation was completed by adding Solution A, LOWINOX™, Solution B, and Solution C. These materials were added 5 minutes apart. Mixing was maintained.

Solution A:

	Antifoggant A:	1.3 parts
	Tetrachlorophthalic acid	0.37 parts
	4-Methylphthalic acid	0.60 parts
5	MEK	20.6 parts
	Methanol	0.36 parts
	LOWINOX™ 221B446	9.5 parts

Solution B:

	DESMODUR™ N3300	0.66 parts
10	MEK	0.33 parts

Solution C:

	Phthalazine	1.3 parts
	MEK	6.3 parts

Protective topcoat Formulation:

15 A stock solution for the protective topcoat for the photothermo-graphic emulsion layer was prepared as follows:

	ACRYLOID A-21	1.3 parts
	CAB 171-15S	32.8 parts
	MEK	377 parts
20	Vinyl sulfone (VS-1)	0.95 parts
	Benzotriazole	0.71 parts
	Antifoggant B	0.63 parts

Twelve different topcoat formulations were prepared using this solution. For Control A, 3.1 parts MEK was added to 14.9 parts of the topcoat
25 formulation. For samples 1-1 to 1-11, a solution comprising the radiation absorbing compound (and amount) listed in TABLE I with 3.1 parts MEK was added to 14.9 parts of the topcoat formulation noted above.

The imaging (silver) and topcoat formulations were simultaneously dual knife coated onto a 178 μm polyethylene terephthalate support to provide
30 photothermographic materials with the topcoat being farthest from the support.

The web (support and applied layers) was conveyed at a rate of 5 meters per minute during both coating and drying. Simultaneous coating allowed the radiation absorbing compound in the topcoat formulation to diffuse down into the imaging layer formulation before drying. Immediately after coating, the samples
5 were dried in an oven at about 85°C for 5 minutes. The imaging layer formulation was coated to provide about 2 g of silver/m² dry coating weight. The topcoat formulation was coated to provide about 2.6 g/m² dry coating weight.

Upon exposure and development, this material was capable of achieving an optical density of about 4.0.

10 The backside of the support was coated with a conventional antihalation layer to provide an absorbance greater than 0.3 between 805 and 815 nm. This absorbance is not included in the absorbance reported in the examples for the frontside of the photothermographic materials.

Part of each photothermographic material prepared in this fashion
15 was cut into an “imaging sample” 1 cm x 5 cm in size. In addition, a sample of the support used for the photothermographic material coated only on the backside with the antihalation formulation and without imaging or topcoat coatings was cut into a “support sample” 1 cm x 5 cm in size. This “support sample” was placed in the reference sample cell of a conventional spectrophotometer (U-3410, Hitachi).
20 The “imaging sample” was placed in the sample cell and the absorbance at the exposure wavelength of 810 nm was measured with the reference automatically subtracted, to give the absorbance of the imaging and topcoat layers. Because the topcoat layer is so thin compared to the imaging layer, and the dyes used quickly diffuse into the imaging layer during coating, this measured absorbance essentially
25 equals the absorbance of each sample’s imaging layer.

For Samples 1-1 to 1-11, a part of each photothermographic material was also cut into a 20 x 25 cm sheet, exposed uniformly with a conventional laser imager at 810 nm, and heat-developed for 15 seconds at 122°C to generate an image with an optical density of about 3.0. Thus, the materials in
30 these examples were imaged and developed to an optical density below that of which the material was capable. The imaged sheets were viewed in transmission

5

Grade = 2: noticeably better than Grade = 1

Grade = 4: noticeably better than Grade = 3

Grade = 6: noticeably better than Grade = 5

10

best of all samples.

15

FIG. 1 graphically shows the relationship between absorbance and

TABLE I

Sample	Dye	Dye Amount	Absorbance	Mottle Rating*
Control A	None	—	0.03	1
1-1	AD-46	0.020 parts	0.56	2
1-2	AD-46	0.025 parts	0.75	3
1-3	AD-1	0.012 parts	0.88	4
1-4	AD-1	0.014 parts	1.01	5
1-5	AD-1	0.016 parts	1.14	6
1-6	AD-2	0.012 parts	0.62	3
1-7	AD-2	0.016 parts	0.90	4

1-8	AD-2	0.020 parts	1.03	6
1-9	AD-3	0.012 parts	0.74	3
1-10	AD-3	0.017 parts	1.04	6
1-11	AD-3	0.020 parts	1.17	7

*Mottle Rating (1 is worst, 7 is best)

Example 2:

5 Photothermographic materials were prepared in a similar fashion to that described in Example 1 except that slide coating was used as the coating method and the web (support and applied layers) were conveyed at a rate of 25 meters per minute during both coating and drying. Mottle was effectively reduced at an absorbance greater than 0.6 and especially at an absorbance greater than 1.0.

10 **Example 3:**

Photothermographic materials were prepared in a similar fashion to that described in Example 1 except that slide coating was used as the coating method and the web (support and applied layers) were conveyed at a rate 100 meters per minute during both coating and drying. Mottle was effectively reduced
15 especially at an absorbance greater than 1.0.

The invention has been described in detail with particular reference to certain preferred embodiments thereof, but it will be understood that variations and modifications can be effected within the spirit and scope of the invention.